

**Classifications**

EN ISO 14341-A:2008	: G 46 2 C G0	AWS A5.18-05	: ER70S-G
	: G 46 2 M G0	KS D 7025	: YGW11
EN ISO 14341-B:2008	: G 49A 2 C G11	JIS Z 3312	: YGW11
	: G 49A 2 M G11		

**Description**

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Excellent defect resistant on high heat input
- Possible to achieve higher productivity due to low spatter and deep penetration
- Beautiful weld appearance on flat or horizontal welding position

**Typical chemical composition of wire (%)**

C	Si	Mn	P	S	Ti
0.06	0.80	1.53	0.014	0.010	0.18

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20°C	Remarks
AWS A5.18	min. 400	min. 480	min. 22		
EN ISO 14341-B	min. 390	490~670	min. 18	≥ 27	CO <sub>2</sub>
Example	490	570	30	110	CO <sub>2</sub>
	520	590	31	120	Mix

**Operating data**

	Dia.(mm)	1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	50 ~ 180	100 ~ 250
	Overhead (PE/4G)	50 ~ 180	100 ~ 250

**Polarity and Shielding gas**

- DCEP (DC+)
- CO<sub>2</sub>: 100% CO<sub>2</sub>
- Mix : Ar+20% CO<sub>2</sub> (15~25ℓ /min.)

**Approvals**

Shielding gas	ABS	BV	DNV	GL	LR	KR	NK
CO <sub>2</sub>	3YSA	SA3YM	III YMS	3YS	3YS H15	3YSG	KSW53G
Mix	-	-	-	-	-	-	KSW53G

\* Others: KS, JIS