K-82T

For 560MPa high tensile steel

Classifications

EN ISO 17632-A:2008	: T50 4 2Ni P C 1 H5	AWS A5.29-10	: E81T1-Ni2C
EN ISO 17632-B:2008	: T55 4 T1-1CA-N5-U H5	AWS A5.36-12	: E81T1/T9-C1A4-Ni2-H4
JIS Z 3313	: T57 4 T1-1CA-N5-U H5		

Description

- It is designed for welding of 560MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a titania type of flux cored wire for all-position welding with 2.0% Ni component
- It feature excellent mechanical properties, easy slag removal, low spatter generaton, smooth bead shape and high X-ray safety

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Ni
CO_2	0.03	0.35	1.17	0.012	0.010	2.02

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30℃	IV (J) -40℃	Remarks
AWS A5.29	min. 470	550~690	min. 19		≥ 27	
EN ISO 17632-B	min. 460	550~740	min. 17		≥ 47	
Example	584	673	24	120	50	CO_2

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- In case of heavy plate welding, preheat and maintain interpass temperature at 100~200℃ in order to prevent crack at low temperatures

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		