K-61T

For 420MPa high tensile steel

Classifications

EN ISO 17632-B:2008	: T43 Z T1-1MA	AWS A5.20-05	: E61T-G
JIS Z 3313	: T43 T1-1MA H10	AWS A5.36-12	: E61T1-M21AY-G
		KS D 7104	: YFW-A430R

Description

- K-61T is designed for MAG welding of POS-AG steel and low silicon steel for all-position welding applications
- It is applicable to use 400MPa class tensile strength steel welding
- It is controll to lower Si component, so suitable for making zinc primer coated tank
- Wire is a titania type flux cored wire that provides smooth arc, good slag removal and bead shape

Welding positions

Polarity & shielding gas

- Mix:Ar+20% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
Mix	0.03	0.12	0.80	0.013	0.009

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0℃	Remarks
AWS A5.20	min. 330	430~600	min. 22		
EN ISO 17632-B	min. 330	430~600	min. 20		
Example	520	580	29	30	Mix

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- We are recommend under the propriety welding condition, Because it is difficult to V-up welding for high current

Package

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