

**Classifications**

EN ISO 17632-A:2008	: T46 0 R C(M) 4 H10	AWS A5.20-05	: E70T-1C/-1M
EN ISO 17632-B:2008	: T49 0 T15-0C(M)A-U H10	AWS A5.36-12	: E70T1-C1/M21A0-CS1-H8
JIS Z 3313	: T49 0 T15-0 C/MA-U H10	KS D 7104	: YFW-C(A)50DM

**Description**

- It is designed for welding of 490MPa high tensile steels with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a metal type of flux cored wire for flat and horizontal position welding
- It has better excellent deposition rate and provides smooth arc, low spatter levels

**Welding positions****Polarity & shielding gas**

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

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	P	S
CO <sub>2</sub>	0.03	0.50	1.45	0.014	0.010

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

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0℃	-20℃	
AWS A5.20	min. 390	490~670	min. 22	≥ 27		
EN ISO 17632-B	min. 390	490~670	min. 18	≥ 47		
Example	520	580	29	70	55	CO <sub>2</sub>

**Notes on usage and welding condition**

- Refer to page 211~213 for more information on usage
- It is possible to use the 100% CO<sub>2</sub> & mixed gas, but you can get more advantage of welding properties when weld with 100% CO<sub>2</sub> gas.

**Package**

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