

Classifications

EN ISO 17632-A:2016	: T42 Z V NO 3	AWS A5.20-2005	: E70T-10
EN ISO 17632-B:2016	: T49 Z T10-1NOS	AWS A5.36-2016	: E70T10S-AZ-CS3
JIS Z 3313-2009	: T49 T10-0 N S	KS D 7104 -2012	: YFW-S50GB

Description

- It is designed for welding of 490MPa high tensile steel and self-shielded wire to facilitate welding outdoors
- (ASTM A36 Gr. All; A109 Gr. All; A283 Gr. A,B,C,D; A284 C,D; A285 Gr. A,B,C; A288 Gr. 1; A372 type I ; A500 Gr. All; A501 Gr. all)
- It has good arc stability, low spatter generation, high efficiency, good bead shape and slag removal
- It has to use DECN (electrode negative)

Welding positions**Polarity & shielding gas**

- DCEN (DC-)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Al
	0.10	0.11	0.53	0.015	0.010	1.10

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.20		min. 490		
EN ISO 17632-B	min. 390	490~670	min. 18	
Example	460	530	22	

Notes on usage and welding condition

Dia.(mm)	2.0	2.4	3.2
Current F (PA/1G)	260 ~ 360	280 ~ 360	300 ~ 400
(Amp.) HF (PC/2G)	(23 ~25)	(24 ~25)	(25 ~27)

- Self-shielded FCW is to more generate a fume than titania type FCW So you have to use the ventilation system in small space

Package

Dia. (mm)	1.6	2.4	3.2
Spool (kg)	15, 20		
Coil (kg)		20, 25, 30	

Approvals

JIS, KS

- * Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.