

Flux Cored Welding Wire

K-NGS4

For 490MPa high tensile steel (Self-Shielded, multi pass)

Classifications

EN ISO 17632-A:2016 : T42 Z Y NO 3

EN ISO 17632-B:2016 : T49 Z T4-ONOA

JIS Z 3313-2009 : T49 T4-0 N A

AWS A5.20-2005 : E70T-4

AWS A5.36-2016 : E70T4-AZ-CS3

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
- Typical applications include general fabrication and structural work requiring no impact properties
- It has good arc stability, low spatter generation, high efficiency, good bead shape and slag removal
- It has to use DECP (electrode positive)

Welding positions



Polarity & shielding gas

- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Al
	0.17	0.22	0.80	0.012	0.007	1.32

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.20	min. 390	490~670	min. 22	
EN ISO 17632-B	min. 390	490~670	min. 18	
Example	460	540	23	

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.