

# KC-27

For mild steel and 490MPa tensile strength steel

## Classifications

EN ISO 14341-A:2008	: G 46 2 M G0	KS D 7025	: YGW15
EN ISO 14341-B:2008	: G 49A 2 M G15	JIS Z 3312	: YGW15
AWS A5.18-05	: ER70S-G		

## Description

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Suited for application of automatic pipe welding with carbon dioxide or mixture gas
- Low spatter and beautiful weld appearance
- Possible to perform with all welding positions and get high impact value in welds

## Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ti
0.07	0.62	1.18	0.014	0.010	0.09

## Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20°C	Remarks
AWS A5.18	min. 400	min. 480	min. 22		
EN ISO 14341-B	min. 390	490-670	min. 18	≥ 27	Mix
Example	490	560	31	160	Mix

## Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	50 ~ 180	100 ~ 250
	Overhead (PE/4G)	50 ~ 180	100 ~ 250

## Polarity and Shielding gas

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

## Approvals

Shielding gas	ABS	DNV	NK
Mix	3YSA	III YMS	KSW53G

\* Others : JIS