ZO-50R

For 490MPa tensile strength steel and welding robot

Classifications

EN 14341-A:2008	: G 46 2 C G0	AWS A5.18-05	: ER70S-G
	: G 46 2 M G0	KS D 7025	: YGW11
EN 14341-B:2008	: G 49A 2 C G11	JIS Z 3312	: YGW11
	: G 49A 2 M G11		

Description

- For robot welding of bridges, structural steel, steel buildings.
- Excellent defect resistant on high heat input
- Possible to achieve higher productivity due to low spatter and deep penetration
- Suited for multi-pass welding due to low slag and easy to remove

Typical chemical composition of weld metal (%)

C	Si	Mn	P	S	Ti
0.09	0.54	0.97	0.011	0.004	0.03

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20℃	Remarks
AWS A5.18	min. 400	min. 480	min. 22		
EN ISO 14341-B	min. 390	490~670	min. 18	≥ 27	
JIS Z 3312	min. 400	490~670	min. 18	≥ 47(@0℃)	
Example	490	570	34	110	As Weld

Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	70 ~ 200	100 ~ 250
	Overhead (PE/4G)	70 ~ 200	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- CO_2 : 100% CO_2 (15~25ℓ /min.)