

**Classifications**

EN ISO 17632-A:2015	: T46 4 P M21 1 H5	AWS A5.20-2005(R2015)	: E71T-1MJ
EN ISO 17632-B:2015	: T49 4 T1-1M21A-U H5	AWS A5.36-2016	: E71T1-M21A4-CS1-H4
JIS Z 3313-2009	: T49 4 T1-1MA-U H5	KS D 7104-2012	: YFW-A(C)502R

**Description**

- It is designed for the welding of 490MP high tensile steels with Ar+20%CO<sub>2</sub> shielding gas.
- Typical applications include railcar, automotive machinery, shipbuilding, bridges, heavy equipment etc
- This wire is a titania type of flux cored wire for all-position welding.
- It features excellent mechanical properties, easy slag removal, low spatter generation, and good impact value at low temperatures down to -40°C

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

- 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	Ni
Mix	0.03	0.40	1.38	0.012	0.011	0.02

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

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-40°C	
AWS A5.20	min. 390	490~670	min. 22	≥ 27		
EN ISO 17632-B	min. 390	490~670	min. 18	≥ 47		
Example	610	640	27	85	65	Mix

**Notes on usage and welding condition**

- Refer to page 219~221 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

**Package**

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

**Approvals**

ABS, BV, DNV\*GL, LR

- \* Please refer to our homepage([www.kiswel.com](http://www.kiswel.com)) for further detailed information regarding approvals.