

Flux Cored Welding Wire

KX-706T

For 490MPa high tensile steel (Non slag type)

Classifications

EN ISO 17632-A:2015 : T42 2 M M21 1 H5
JIS Z 3313-2009 : T49 3 T15-1MA H5

AWS A5.18-2005 : E70C-6M
AWS A5.36-2016 : E71T15-M21A2-CS1-H4
KS D 7104-2012 : YFW-A502M

Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a metal type of flux cored wire for all positional welding
- It has better stable arc with spray, good toe wetting
- It feature good penetration, high resistance to porosity, good wetting behaviour as well as low hydrogen contents
- KX-706T is intended for semi-automatic, automatic, single- and multiple pass welding

Welding positions



Polarity & shielding gas

- Mix: Ar+20% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
Mix	0.05	0.39	1.64	0.010	0.010

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.18	min. 400	min. 480	min. 22		≥ 27	
EN ISO 17632-B	min. 390	490~670	min. 18		≥ 27	
Example	465	587	28	77	48	Mix

Package

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