

FOR HIGH TENSILE
STRENGTH STEEL

AWS ER70S-6
JIS YGW12
KS YGW12

KC-28

Typical applications

Butt and fillet welding of vehicles, building, ships, machinery and bridges in all positions.

Characteristics on Usage

- ① Suitable for high speed welding of steel sheets by short circuiting transfer in all positions.
- ② Flow quantity of shielding gas should be 20ℓ /min in general.
- ③ Keep the distance between tip and base plate metal 6~15mm for 250 Amp. and under or within 15~25mm for more than 250 Amp. of welding current.

Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.07	0.86	1.53	0.012	0.007

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-29°C)
CO ₂	450 {46}	550 {56}	30	70 {7}
Ar+20%CO ₂	480 {49}	580 {59}	28	80 {8}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	0.9	1.0	1.2	1.4	1.6
Amp.	F	50~200	70~250	100~350	140~400	200~550
	V&OH	50~120	50~150	50~180	100~250	120~300

Package

Dia.	(mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool	(kg)	5, 15, 20					
Pailpack	(S)	200, 250		250, 300,		-	
Pailpack	(B)	-		350,400,450			

Approved by

ABS, BV, CCS, CWB, DNV, GL, LR, KR, NK, TÜV, JIS,KS,
(80%Ar + 20% CO₂ : ABS, TÜV, JIS, KS)