Flux Cored Welding Wire

KX-706MU

For 490MPa high tensile steel (Non slag type)

Classifications

EN ISO 17632-A:2015	: T46 4 M M21 3 H5	AWS A5.18-2005	: E70C-6M
EN ISO 17632-B:2015	: T49 4 T15-0M21A-U H5	AWS A5.36-2016	: E70T15-M21A4-CS1-H4
JIS Z 3313-2009	: T49 4 T15-0MA U H5	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 flat and horizontal position welding
- It has better CVN toughness(-40℃) at low temperatures when compared to the KX-706M
- It feature good penetration, high resisitance to porosity, good wetting behaviour as well as low hydrogen contents
- KX-706MU is intended for semi-automatic, automatic, single and multiple pass welding

Welding positions

Polarity & shielding gas

- Mix: Ar+20% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
Mix	0.04	0.70	1.60	0.010	0.009

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30℃	IV (J) -40℃	Remarks
AWS A5.18	min. 400	min. 480	min. 22	≥ 27		
EN ISO 17632-A	min. 460	530~680	min. 20		≥ 47	
Example	557	634	24	87	74	Mix

Notes on usage and welding condition

Dia.(mm)		1.2	1.4	1.6
Current (Amp.)	F (PA/1G)	160 ~ 340	200 ~ 380	240 ~ 420
	HF (PC/2G)	(24 ~ 32)	(25 ~ 33)	(26 ~ 35)

Package

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