

# G-50×KD-50

**AWS** F7A2-EH14  
**JIS** S502-H  
**KS** FS-FG2×YS-56

FOR HIGH TENSILE  
 STRENGTH STEEL

## Typical applications

Butt and fillet welding of ships, machines, bridges, steel structures and general fabrications.

## Characteristics on Usage

- ① Insensitive to rust, scales, oil dirt of the surface to be welded.
- ② Excellent resistance against porosities.
- ③ Economical because of less consumption of flux and high melting ratio.

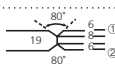
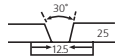
## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S	Base metal	
					Class	Thick (mm)
0.12	0.24	1.38	0.013	0.011	SM 400	20
0.07	0.33	1.78	0.016	0.012	SM 490	25

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	Charpy V-notch J (kgf · m)		Base metal	
			-29°C	0°C	Class	Thick (mm)
390 {40}	500 {51}	30	30 {3}	40 {4}	SM 400	20
410 {42}	520 {53}	30	60 {6}	80 {8}	SM 490	25

## Typical welding conditons

Thick (mm)	Wire dia. (mm)	Groove dimension (mm)	Amp.	Volt.	Welding method	Travel speed (cm/min)	Pass
20	4.8		800	35	General	42	①
			900	37		34	②
25	4.0		600	30	AWS A 5.17	40~50	1~14

Approved by