

FOR MILD STEEL

**AWS E61T-G**  
**JIS YFW-A430R**  
**KS YFW-A430R**

**K-61T****Typical applications**

K-61T is designed for MAG welding of POS-AG steel and low silicon steel for single and multi-pass applications.

**Characteristics on Usage**

- ① Wire is a titania type flux cored wire applicable for all-position welding.
- ② It is applicable to use 400MPa class tensile strength steel welding.
- ③ It provides smooth arc and low spatter generation, good slag removal in using shielding gas 75~80%Ar+CO<sub>2</sub>.
- ④ It is free from porosity and good radiographic soundness.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S
Ar+20%CO <sub>2</sub>	0.03	0.12	0.80	0.013	0.012

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

Shielding Gas	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} (0°C)
Ar+20%CO <sub>2</sub>	395 {40}	487 {49}	31	30 {3}

**Sizes available and recommended currents (DC wire⊕)**

Dia.	(mm)	1.2	1.4	1.6
Amp.	F	140~340A	180~440A	200~460A
	H	140~340A	180~440A	200~460A
	V	140~260A	180~260A	200~260A

**Package**

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)	5, 12.5, 15, 20		

**Welding positions**

Approved by