

K-70ST
AWS E70T-1
JIS YFW-C502R
KS YFW-C502R
**FOR HIGH TENSILE
STRENGTH STEEL**

Typical applications

K-70ST is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. It is most suitable for fillet welding of inorganic zinc-primer coated steels often used in the machineries, steel fabrications and construction industries.

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for flat and horizontal position welding.
- ② K-70ST has very efficient welding due to higher deposition rate particularly.
- ③ The arc characteristics are so smooth and stable, even the most novice welder can produce good welds.
- ④ It has easy slag removal and bigger leg of fillet welding is easier.
- ⑤ The shielding gas should be used 100%CO₂ for welding.
- ⑥ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S
CO ₂	0.04	0.49	1.36	0.015	0.013

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 }	El (%)	Charpy V-notch J {kgf · m} (-20°C)
CO ₂	484 {49}	584 {59}	28	60 {5}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	140~340	200~460
	H-Fil	160~360	200~460

Package

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

Welding positions



Approved by

ABS, BV, DNV, GL, KR, LR, NK, JIS, KS