

FOR HIGH TENSILE  
STRENGTH STEEL

AWS E70T-1/-1M  
JIS YFW-C50DM  
KS YFW-C50DM

**K-70T**

### Typical applications

K-70T is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structuresbridges and general fabrications.

### Characteristics on Usage

- ① Wire is a metal type of flux cored wire for flat and horizontal position welding.
- ② It has better excellent deposition rate when compared to conventional K-71T wire.
- ③ It also provides smooth arc, low spatter levels, beautiful bead appearance.
- ④ The shielding gas should be used 100%CO<sub>2</sub> or Ar+20~25%CO<sub>2</sub> for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S
CO <sub>2</sub>	0.03	0.50	1.45	0.014	0.013

### 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} (-20°C)
CO <sub>2</sub>	540 {55}	570 {58}	25	65 {7}

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

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

### Package

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

### Welding positions



Approved by

JIS, KS