

FOR HIGH TENSILE
STRENGTH STEEL

AWS E70T-5M
JIS YFW-A502B
KS YFW-A502B

K-70TB

Typical applications

K-70TB is designed for welding of 490MPa high tensile steel with only Ar/CO₂ mixtures. Typical applications is general fabrication where the risk of hydrogen-induced cracking is to be avoided.

Characteristics on Usage

- ① Wire is a fully basic type of flux cored wire for flat and horizontal position welding.
- ② It has good CVN toughness at low temperatures and the weldability is excellent with lower crack susceptibility.
- ③ It provides soft welding arc and low spatter levels due to the usage of mixture gas
- ④ The shielding gas should be used Ar+20~25%CO₂ 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
Ar+20%CO ₂	0.04	0.34	1.30	0.016	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} (-30°C)
Ar+20%CO ₂	490 {50}	550 {56}	29	50 {5}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F H-Fil	120~300	200~450

Package

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

Welding positions



Approved by