

FOR LOW TEMPERATURE SERVICE STEEL

AWS E80T1-K2
JIS YFL-C506M
KS YFL-C506M

K-80TK2

Typical applications

K-80TK2 is designed for welding of 590MPa high tensile steel for low temperature service. Butt and fillet MAG welding of offshore structures, LNG and LPG carriers and storage tank, etc.

Characteristics on Usage

- ① Wire is a metal type of flux cored wire for flat and horizontal position welding.
- ② The weld metal contains about 1.5%Ni and has good impact value at low temperatures down to -60°C.
- ③ It provides excellent usability with stable arc, low spatter levels and deposition rate is much higher than a titania type.
- ④ It has good porosity resistance and is applicable for fillet welding of inorganic zinc-primer coated steels
- 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	Ni
CO ₂	0.03	0.45	1.50	1.5

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} (-60°C)
CO ₂	550 {56}	640 {65}	25	50 {5}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F H-Fil	120~340	200~450

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