

Typical applications

K-82T is formulated for welding of 590MPa high tensile steel with outstanding mechanical properties. It is the most suitable for butt welding of aluminium-killed 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 all-position welding.
- ② The weld metal contains about 2.0%Ni and has good impact value at low temperatures down to -40°C.
- ③ It features excellent mechanical properties, easy slag removal, low spatter loss, smooth bead surface, high X-ray safety.
- ④ The shielding gas should be used 100%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	Ni
CO ₂	0.03	0.48	1.26	0.011	0.009	2.0

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 }	EI (%)	Charpy V-notch J {kgf · m} (-40°C)
CO ₂	584 {59}	673 {68}	24	50 {5}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	140~360	200~420
	H-Fil	140~260	180~260
	V	140~260	180~260

Package

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

Welding positions



Approved by