

FOR HIGH TENSILE
STRENGTH STEEL

AWS E71T-GS
JIS YFW-S50GB
KS YFW-S50GB

K-NGS

Typical applications

K-NGS is a self-shielded flux cored wire for lap and fillet welds of mild and medium tensile steels not exceeding 510MPa. It is suitable for a variety of applications such as prefab, building fabrication, tanks, ornamental iron, farm implement, repairs and general fabrication.

Characteristics on Usage

- ① Wire is for all-positional welding of single pass automatic and semi-automatic fabrications.
- ② It can be applicable for aluminized steel and galvanized steel from 1.2 to 5.0mm.
- ③ It is designed for on site general fabrication and structural work requiring no impact properties.
- ④ It can be used DCEN polarity.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S	Al
—	0.16	0.31	0.82	0.014	0.006	1.3

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P Nmm ² {kgf/mm ² }	Longitudinal Guided Bend Test
—	520 {53}	No Defects

Sizes available and recommended currents (DC wire^{⊕, ⊖})

Dia.	(mm)	1.2	1.6	2.0
Amp.	F H-Fil	80~200	160~270	180~280

Package

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

Welding positions



Approved by
CWB