

FOR HIGH TENSILE
STRENGTH STEEL

AWS E71T-10
JIS YFW-S50GB
KS YFW-S50GB

K-NGS10

Typical applications

K-NGS10 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 fabrications.
- ② It has good arc stability, low spatter generation, high efficiency, good bead appearance and slag removal.
- 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
—	0.10	0.11	0.53	0.016	0.006	1.1

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 (%)
—	480 {49}	530 {54}	22

Sizes available and recommended currents (DC wire[⊖])

Dia.	(mm)	1.6	2.4	3.2
Amp.	F	80~200	160~270	180~280
	H-Fil	80~160	120~220	—

Package

Dia.	(mm)	1.6	2.4	3.2
Spool	(kg)	5, 12.5, 15, 20		
Pailpack	(kg)	100~300		

Welding positions



Approved by