

K-NGS11

AWS E71T-11
JIS YFW-S50GB
KS YFW-S50GB

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

K-NGS11 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- and mutple pass fabrications.
- ② The arc characteristics are so smooth and stable, even the most novice welder can produce good welds.
- 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	0.10	0.55	0.016	0.006	1.2

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P	T · S	EI
	N/mm ² {kgf/mm ² }	N/mm ² {kgf/mm ² }	(%)
—	500 {51}	530 {54}	23

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

Dia.	(mm)	1.2	1.6	2.0
Amp.	F	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