

K-NGS4

AWS E70T-4
JIS YFW-S50GB
KS YFW-S50GB

**FOR HIGH TENSILE
STRENGTH STEEL**

Typical applications

The welding of heavy machinery, large construction components where appropriate, and stiffeners in large building. This wire is intended for semi-automatic and automatic, single- and multiple-pass welding in the flat and horizontal positions.

Characteristics on Usage

- ① Extremely high deposition rates can be achieved.
- ② K-NGS4 is self-shielded flux cored wire to facilitate welding outdoors.
- ③ It has good arc stability, low spatter generation, high efficiency, good bead appearance and slag removal.
- ④ It is designed for on site general fabrication and structural work requiring no impact properties.
- ⑤ It can be used DCEP (reverse polarity).
- ⑥ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S	Al
—	0.17	0.22	0.80	0.012	0.007	1.32

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 (%)
—	460 {47}	540 {55}	23

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.6	2.4	3.2
Amp.	F	200~360	240~400	300~500
	H-Fil	200~380	240~420	300~500

Package

Dia.	(mm)	1.6	2.4	3.2
Spool	(kg)	12.5, 15, 20		
Coil	(kg)	20, 25, 30		

Welding positions



Approved by