

FOR HIGH TENSILE  
STRENGTH STEEL

AWS ER70S-3  
JIS YGW14  
KS YGW14

**KG-25**

### Typical applications

Butt and fillet welding of transportation vehicles, cars, bridges and industrial machinery.

### Characteristics on Usage

- ① Suitable for high speed welding of steel sheet by short circuiting transfer in all position.
- ② Stable arc and low spatter loss.
- ③ Applicable to mixture gas(Ar+20% CO<sub>2</sub>)

### Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.07	0.67	1.20	0.015	0.011

### Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	Charpy V-notch J {kgf · m} (-18°C)
CO <sub>2</sub>	430 {44}	520 {53}	33	90 {9}

### Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	0.8	0.9	1.0	1.2	1.4	1.6
Amp.	F	50~120	50~140	80~250	100~350	140~400	200~450
	V&OH	50~100	50~120	60~150	70~200	100~250	120~300

### Package

Dia.	(mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool	(kg)	5, 15, 20					
Pailpack	(S)	200, 250			250, 300, 350		-
Pailpack	(B)	-			350, 400, 450		

### Approved by

ABS, CWB, DNV, KR, LR, NK, JIS, KS