

KG-25M

AWS ER70S-3
JIS YGW16
KS YGW16

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

Butt and fillet welding of structures such as chemical equipment and pressure vessels.

Characteristics on Usage

- ① Good usability can be obtained by wide range welding from low to high currents.
- ② Stable arc and low spatter.

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 ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-18°C)
Ar+20%CO ₂	440 {45}	540 {55}	30	100 {10}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	0.9	1.0	1.2	1.4	1.6
Amp.	F	50~200	70~250	100~350	140~400	200~550
	V&OH	50~120	50~150	50~180	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		-	
Pailpack	(B)	-		350,400,450			

Approved by