

KG-27 AWS ER70S-G
 JIS YGW15
 KS YGW15

FOR HIGH TENSILE
 STRENGTH STEEL

Typical applications

Butt and fillet welding of vehicles, steel frames, bridges, machinery and shipbuilding

Characteristics on Usage

- ① Applicable to Ar+15~25% CO₂ mixture gas.
- ② Stable arc, low spatter and less slag formation.
- ③ The deposited weld metal has an excellent notch toughness.
- ④ Beautiful bead appearance is obtained by spray transfer.

Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.07	0.62	1.18	0.014	0.010

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 }	El (%)	Charpy V-notch J {kgf · m} (-18°C)
Ar+20%CO ₂	490 {50}	560 {57}	31	160 {16}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.4	1.6
Amp.	F	100~350	140~400	200~550
	V&OH	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

ABC, DNV, NK, JIS