

KG-70S2

AWS ER70S-2

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

Butt and fillet welding of vehicles, cars, ships, machineries and bridges.

Characteristics on Usage

- ① Arc is very stable and can be used for welding steels which have a rusty or dirty surface because wire has a triple deoxidizer (Al, Ti, Zr).
- ② It is able to obtain the good bead appearance with the use of Ar+CO₂ mixtures as shielding gas.

Typical chemical composition of wire (%)

C	Si	Mn	Ti	Al	Zr
0.07	0.54	1.18	0.07	0.08	0.05

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} (-29°C)
CO ₂	490 {50}	550 {56}	29	80 {8}
Ar+20%CO ₂	550 {56}	610 {62}	26	50 {5}

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	-

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