

FOR HIGH TENSILE  
STRENGTH STEEL

AWS E70C-3C  
JIS YFW-C50DM  
KS YFW-C50DM

**KX-100**

### Typical applications

Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.

### Characteristics on Usage

- ① Wire is a metal type of flux cored wire for flat and horizontal position welding.
- ② Deposition rate is up to 20% higher than a solid wire's one.
- ③ Slag quantity is almost the same as a solid wire and multiple pass welding can be performed without removing slag.
- ④ The shielding gas should be used 100%CO<sub>2</sub> for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S
CO <sub>2</sub>	0.04	0.54	1.55	0.014	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> }	El (%)	Charpy V-notch J {kgf · m} (-20°C)
CO <sub>2</sub>	510 {52}	550 {56}	29	60 {6}

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

Dia.	(mm)	1.2	1.6
Amp.	F	140~340	200~460
	H-Fil		

### Package

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)	5, 12.5, 15, 20		

### Welding positions



### Approved by

ABS, BV, DNV, GL, KR, LR, NK, JIS, KS