

KX-200

AWS E70T-1
JIS YFW C50DM
KS YFW C50DM

**FOR HIGH TENSILE
STRENGTH STEEL**

Typical applications

KX-200 is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. 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 It provides excellent usability with stable arc, low spatter levels and deposition rate is much higher than a titania type.
- ③ It has good porosity resistance and is applicable for fillet welding of inorganic zinc- primer coated steels
- ④ The shielding gas should be used 100%CO₂ 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 ₂	0.04	0.41	1.25	0.014	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 }	El (%)	Charpy V-notch J {kgf · m} (-20°C)
CO ₂	510 {52}	550 {56}	27	50 {5}

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		
Pailpack	(kg)	100~300		

Welding positions



Approved by

ABS, BV, CCS, DNV, GL, KR, LR, NK, TÜV, JIS, KS
 (80%Ar + 20%CO₂)