

FOR HIGH TENSILE  
STRENGTH STEEL

AWS E70T-1  
JIS YFW-C502M  
KS YFW-C502M

# KX-200H

## Typical applications

KX-200H 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 has better CVN toughness at low temperatures when compared to the KX-200.
- ③ It has good porosity resistance and is applicable for fillet welding of inorganic zinc- primer coated steels
- ④ KX-200H is intended for semi-automatic, automatic, single- and multiple pass welding.
- ⑤ The shielding gas should be used 100%CO<sub>2</sub> for welding.
- ⑥ 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>	0.037	0.56	1.61	0.013	0.012

## 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>	517 {53}	610 {62}	28	70 {7}

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

Dia.	(mm)	1.2	1.4	1.6
Amp.	F	160 - 340A	180 - 400A	160 - 460A
	H-Fil	180 - 360A	180 - 420A	180 - 460A

## 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, DNV, GL, KR, LR, JIS, KS