

KX-300

AWS E80T1-Ni1
JIS YFW-C602M
KS YFW-C602M

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

KX-300 is designed for welding of 590MPa high tensile steel with rapid fillet welding in HV position. 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 KX-300 is intended for semi-automatic, automatic, single- and multiple pass welding.
- 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	Ni
CO ₂	0.024	0.47	1.34	0.014	0.013	0.97

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 }	EI (%)	Charpy V-notch J {kgf · m} (-29°C)
CO ₂	610 {62}	640 {65}	25	47 {5}

Sizes available and recommended currents (DC wire[⊕])

Dia.	(mm)	1.2	1.4	1.6
Amp.	F	160~340A	180~400A	200~460A
	H-Fil	180~360A	180~420A	200~460A

Package

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)	5, 12.5, 15, 20		
Pailpack	(kg)	100~300		

Welding positions



Approved by