

# KX-70CM

**AWS E70C-3M**  
**JIS YFW - A50DM**  
**KS YFW - A50DM**

**FOR HIGH TENSILE  
STRENGTH STEEL**

## Typical applications

KX-70CM is designed for welding of 490MPa high tensile steel with only Ar/CO<sub>2</sub> mixtures. It is especially suitable for fillet welding and has a high tolerance to primer.

## Characteristics on Usage

- ① Wire is a metal type of flux cored wire for flat and horizontal position welding.
- ② Slag quantity is almost the same as a solid wire and multiple pass welding can be performed without removing slag.
- ③ 20% higher productivity can be achieved when compared to solid wires.
- ④ KX-70CM is intended for semi-automatic, automatic, single- and multiple pass welding.
- ⑤ The shielding gas should be used Ar+20~25%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
Ar+20%CO <sub>2</sub>	0.03	0.40	1.60	0.014	0.013

## 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℃)
Ar+20%CO <sub>2</sub>	480 {49}	540 {55}	29	55 {6}

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

Dia.	(mm)	1.2	1.4	1.6
Amp.	F	160~340	180~420	240~450
	H-Fil	180~350	220~380	280~450

## Package

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

## Welding positions



## Approved by

ABS, BV, DNV, GL, LR, RINA, JIS, KS  
 (80%Ar+20%CO<sub>2</sub>:TÜV)