

Classifications

EN ISO 17632-A:2008	: T46 0 P C 1 H10	AWS A5.20-05	: E71T-1C
EN ISO 17632-B:2008	: T49 0 T1-1CA-U H10	AWS A5.36-12	: E71T1-C1A0-CS1-H8
JIS Z 3313	: T49J 0 T1-1CA-U H10	KS D 7104	: YFW-C50DR

Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a titania type of flux cored wire for all-position welding
- It feature excellent mechanical properties, easy slag removal, low spatter generation, smooth bead shape, high X-ray safety

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
CO ₂	0.04	0.55	1.25	0.015	0.011

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
AWS A5.20	min. 390	490~670	min. 22	≥ 47	≥ 27	
EN ISO 17632-B	min. 390	490~670	min. 20	≥ 47	70	
Example	520	580	29	70	55	CO ₂

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

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

Approvals

Shielding gas	ABS	BV	DNV	CCS	LR	NK	KR
CO ₂	2YSAH10	SA2YM	II Y40MS	3S3YS	2YSH15	KSW52Y40G	2YSGH10