

Copper Free Wire
KC-28CF



CF(Copper Free) Wire has numerous strong points in comparison with the conventional Cu-Coated wire. It is the KISWEL family's ongoing concern to enhance outstanding Feedability, Consistent Cast / Helix and Welding Productivity by reducing the down time in the automatic welding process performed by robots as well as to improve the working environment and welders' health that will result in superior welding quality.



KISWEL

KC-28CF

AWS ER70S-6
JIS YGW12

FOR HIGH TENSILE STRENGTH STEEL

Typical applications

Suitable for the butt and fillet welding in all positions.
Single arc or Tandem applications for pipe welding, pressure vessels, steel buildings and structural steel welding.

Characteristics on Usage

- ① Trouble-free (Outstanding) feedability increased arc time & productivity and reduced downtime & replacement liners.
- ② Excellent arc stability leads to first-class spatter control and bead appearance.
- ③ Copper Free Wire for less toxic copper fumes.
- ④ No copper flaking to clogged tips and liners.
- ⑤ Improved welding uniformity and welding quality.
※ Controlled wire cleaning is your assurance of uniform performance and quality.

Typical chemical composition of Wire (%)

C	Si	Mn	P	S
0.07	0.90	1.50	0.013	0.010

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. (%)	Impact Value J {kgf · m} (-29°C)
100%CO ₂	465 {47}	556 {57}	30	90 {9}
Ar+20%CO ₂	480 {49}	580 {59}	29	100 {10}

Welding current recommendation (DC +)

Dia. (Inches)		0.030	0.035	0.040	0.045	0.052	0.062
Amp. (A)	F	50 ~ 120	50 ~ 200	70 ~ 250	100 ~ 350	140 ~ 400	200 ~ 550
	V&OH	20 ~ 100	50 ~ 120	50 ~ 150	50 ~ 180	100 ~ 250	120 ~ 300

Packing

Lb.	Dia.(Inches)	0.030	0.035	0.040	0.045	0.052	0.062
Spool		33 & 44					
Pail Pack		550 & 650					

KISWEL LTD. Seoul Office

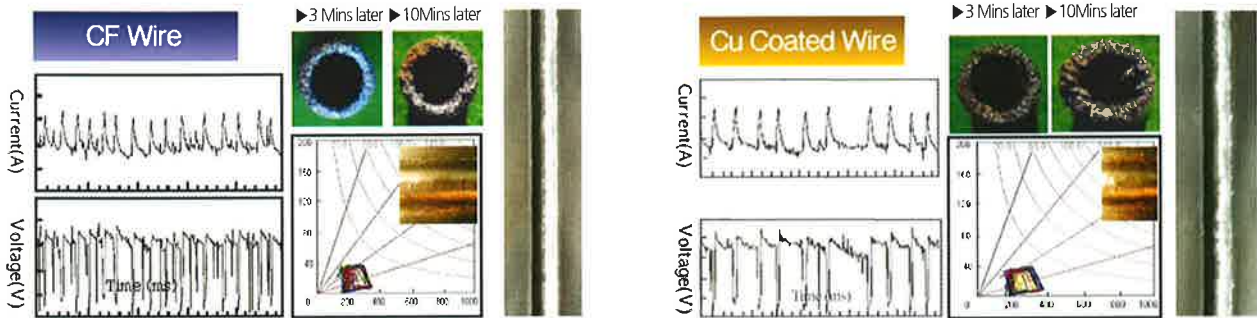
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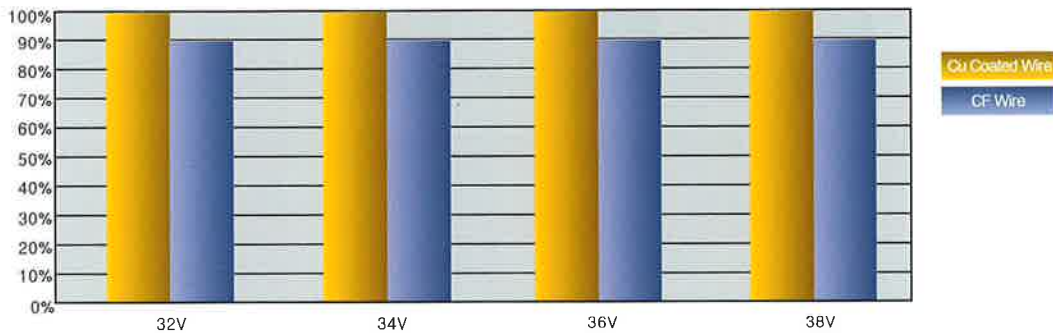
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ENHANCED WELDABILITY

CF (Copper Free) wire has stabilized the variation of current / voltage as well as welding arc, which guarantees better bead appearance.

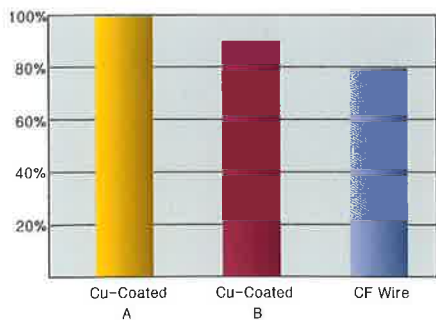


Stabilized welding arc serves to minimize the spatter quantity & size.



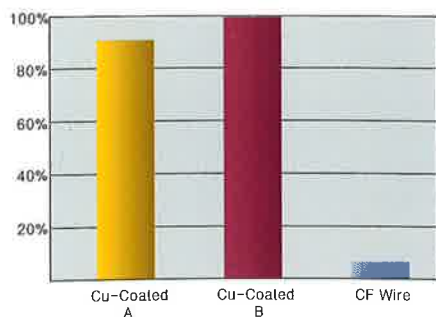
REDUCED ENVIRONMENTAL LOAD

Welding Fume generation is reduced by minimum 15%.
 Copper Fume generation is reduced by minimum 95%.
 Less Toxic gas is discharged.



Reduced Welding Fume by 20%

Welding Fume is increased especially when arc is fluctuated. Fume quantity depends on the residual surface. Stabilized welding arc and well treated surface condition reduce the fume.



Reduced Cu Fume by 95%

Cu Fume is particularly generated from the Cu-Coated layer of the surface. CF Wire has almost No Cu-Fume.



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