

Flux Cored Welding Wire

KX-200H

For 490MPa high tensile steel

Classifications

EN ISO 17632-A:2015	: T42 2 R C1 3 H10	AWS A5.20-2005(R2015)	: E70T-9C
EN ISO 17632-B:2015	: T49 2 T1-0C1A-U H10	AWS A5.36-2016	: E70T1-C1A2-CS1-H8
JIS Z 3313-2009	: T49 2 T1-0CA-U H10	KS D 7104-2012	: YFW-C50DM

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 metal type of flux cored wire for flat and horizontal position welding
- It has better CVN toughness at low temperatures when compared to the KX-200
- KX-200H is intended for semi-automatic, automatic, single- and multiple pass welding

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	0.56	1.61	0.013	0.010

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20℃	-30℃	
AWS A5.20	min. 390	490-670	min. 22		≥ 27	
EN ISO 17632-B	min. 390	490-670	min. 18	≥ 47		
Example	517	610	28	80	50	CO ₂

Notes on usage and welding condition

Dia.(mm)	1.2	1.4	1.6
Current F (PA/1G)	140 ~ 300	160 ~ 360	180 ~ 420
(Amp.) HF (PC/2G)	180 ~ 300	180 ~ 350	220 ~ 400

- Zinc primer coated steels should be enough drying when you use

Package

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

Approvals

ABS, BV, DNV*GL, LR, NK, RS, KS, JIS, TUV

- * Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.