

Flux Cored Welding Wire

K-NGS11

For 490MPa high tensile steel (Self-Shielded, multi pass)

Classifications

EN ISO 17632-A:2016	: T42 Z Y NO 1	AWS A5.20-2005	: E71T-11
EN ISO 17632-B:2016	: T49 Z T11-1NOA	AWS A5.36-2016	: E71T11-AZ-CS3
JIS Z 3313-2009	: T49 T7-1 N A	KS D 7104 -2012	: YFW-S50GB

Description

- It is designed for welding of 490MPa high tensile steel and self-shielded wire to facilitate welding outdoors
- Typical applications include general fabrication and structural work requiring no impact properties (ASTM A36 Gr. All; A109 Gr. All; A283 Gr. A,B,C,D; A284 C,D; A285 Gr. A,B,C; A288 Gr. 1; A372 type I ; A500 Gr. All; A501 Gr. all)
- It has good arc stability, low spatter generation, high efficiency, good bead shape and slag removal
- It has to use DCEN (electrode negative)

Welding positions



Polarity & shielding gas

- DCEN (DC-)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Al
	0.10	0.10	0.55	0.015	0.006	1.21

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.20	min. 390	490~670	min. 20	
EN ISO 17632-B	min. 390	490~670	min. 18	
Example	500	530	23	

Notes on usage and welding condition

Dia.(mm)	0.9	1.2	1.6
Current F (PA/1G)	80 ~ 120	120 ~ 180	240 ~ 280
(Amp.) HF (PC/2G)	(18 ~22)	(21 ~23)	(22 ~24)
VU (PF/3G)	100 ~ 160(22 ~25)		

- Self-shielded FCW is to more generate a fume than titania type FCW So you have to use the ventilation system in small space

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15, 20		
Coil (kg)			20, 25

Approvals

JIS, KS

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