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**NOCKERS**  
 ENGINEERING PRODUCTS

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**FLUX CORE WIRES FOR HIGH TENSILE STRENGTH STEEL (430~490MPA)**

Brand Name	Size (mm)	Equivalent Specification	Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)								Typical Mechanical Properties of All-Weld Metal				Characteristics and Applications	Approvals
						C	Si	Mn	P	S	Cr	Ni	Mo	Y.S (MPa)	T.S (MPa)	EI. (%)	I.V (J)		
K-61T	1.2~1.6	AWS A5.20 E61T-G JIS Z 3313 T43 0 T1-1M A KS D 7104 YFW-A430R EN ISO 17632-A T35 Z PM1 EN ISO 17632-B T43 Z T1-1M A	F,V,OH, H,VD	Ar+20%CO <sub>2</sub>	DC(+)	0.03	0.12	0.80	0.013	0.010	-	-	-	420	480	31	20 (-20°C)	K-61T is designed for MAG welding of POS-AG steel and low silicon steel for all-position welding applications.	CE, JIS, KS
K-70T	1.2~1.6	AWS A5.20 E70T-1C / 1M JIS Z3313 T49J 0 T1-0 C/M A-U KS D7104 YFW-C(A)50DM EN ISO 17632-A T46 0 R C/M 4 EN ISO 17632-B T49 2 T1-0 C/M A	F, H-Fil	CO <sub>2</sub> / Ar+20%CO <sub>2</sub>	DC(+)	0.03	0.50	1.45	0.014	0.010	-	-	-	520	580	29	55 (-20°C)	K-70T is designed for welding of 490MPa high tensile steels with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.	CE, JIS

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