



**FLUX CORE WIRES FOR HIGH TENSILE STRENGTH STEEL (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-71T	1.2~2.4	AWS A5.20 E71T-1C JIS Z 3313 T49J 0 T1-1 CA-U YFW- KS D 7104 C50DR EN ISO 17632-A T42 0 PC1 EN ISO 17632-B T49 0 T1-1 CA-U	F,V,OH, H,VD	CO <sub>2</sub>	DC(+)	0.04	0.55	1.25	0.015	0.012	-	-	-	520	580	29	70 (0°C) 55 (-20°C)	K-71T is designed for welding of 490MPa high tensile steels with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.	ABS, BV, DNV, GL, LR, KR, NK, CCS, RINA, CWB, CE, KS, JIS
K-71TLF	1.2~2.4	AWS A5.20 E71T-1C / 1M JIS Z 3313 T49 2 T1-1 C/M A-U YFW- KS D7104 C(A)502R EN ISO 17632-A T46 2 P C/M 1 EN ISO 17632-B T49 2 T1-1 C/M A-U	F,V,OH, H,VD	CO <sub>2</sub> / Ar+20%CO <sub>2</sub>	DC(+)	0.03	0.38	1.35	0.015	0.010	-	-	-	520	570	28	80 (-20°C)	K-71TLF is designed for welding of 490MPa high tensile steels with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.	ABS, BV, DNV, GL, LR, KR, NK, RINA, CWB, TUV, DB, CE, KS, JIS
K-71TM	1.2~2.4	AWS A5.20 E71T-1C / 1M JIS Z3313 T49 2 T1-1 C/M A-U YFW- KS D7104 C(A)502R EN ISO 17632-A T46 2 PC(M)1 EN ISO 17632-B T49 2 T1-1C(M)A	F,V,OH, H,VD	CO <sub>2</sub> / Ar+20%CO <sub>2</sub>	DC(+)	0.03	0.59	1.44	0.013	0.010	-	-	-	580	620	27	65 (-20°C)	K-71TM is designed for welding of 490MPa high tensile steels with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.	ABS, BV, DNV, LR, RINA, CE, KS, JIS
K-70TB	1.2~2.4	AWS A5.20 E70T-5M JIS Z3313 T49 2 T5-0 M A-U YFW- KS D7104 A502B EN ISO 17632-A T46 2 B M 4 T49 3 T5-0 M A EN ISO 17632-B	F, H-Fil	Ar+20%CO <sub>2</sub>	DC(+)	0.04	0.34	1.30	0.015	0.011	-	-	-	490	550	29	60 (-30°C)	K-70TB is designed for welding of 490MPa high tensile steels with only Ar/CO <sub>2</sub> mixtures. Wire is a fully basic type of flux cored wire for flat and horizontal position welding.	CE, JIS
K-71TB	1.2~2.4	AWS A5.20 E71T-5C / 5M T49 3 T5-1 JIS Z3313 C/M A YFW-C(A)502B T46 2 KS D7104 B C/M 1 T49 3 T5-1 C/M A EN ISO 17632-A EN ISO 17632-B	F,V,OH, H,VD	CO <sub>2</sub> / Ar+20%CO <sub>2</sub>	DC(+)	0.02	0.60	1.60	0.015	0.011	-	-	-	550	610	30	55 (-30°C)	K-71TB is designed for welding of 490MPa high tensile steels with only Ar/CO <sub>2</sub> mixtures. Wire is a fully basic type of flux cored wire for flat and horizontal position welding. It has excellent CVN impact properties at sub- zero temperatures.	CE, JIS
K-70ST	1.2~1.6	AWS A5.20 E70T-1C JIS Z3313 T49 2 T1-0 CA-U YFW- KS D7104 C50DR T46 2 R C 4 EN ISO 17632-A T49 2 T1-0 CA-U EN ISO 17632-B	F, H-Fil	CO <sub>2</sub>	DC(+)	0.04	0.49	1.36	0.015	0.010	-	-	-	500	600	27	68 (-20°C)	K-70ST is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. It is the most suitable for fillet welding of inorganic zinc-primer coated steels often used in the machineries, steel fabrications and construction industries.	ABS, BV, DNV, GL, LR, NK, KR, RINA, CE, KS, JIS
KX-100	1.2~1.6	AWS A5.18 E70C-3C JIS Z3313 T49J 0 T15-0 CA-U YFW- KS D7104 C50DM EN ISO 17632-A T46 0 M C 4 EN ISO 17632-B T49 0 T15-0 CA-U	F, H-Fil	CO <sub>2</sub>	DC(+)	0.04	0.54	1.55	0.014	0.011	-	-	-	510	550	29	60 (-20°C)	KX-100 is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Slag quantity is almost the same as a solid wire and multiple pass welding can be performed without removing slag.	ABS, BV, DNV, GL, LR, NK, KR, CE, KS, JIS
KX-200	1.2~1.6	AWS A5.20 E70T-1C JIS Z3313 T49J 0 T1-0 CA-U YFW- KS D7104 C50DM EN ISO 17632-A T46 0 R C 4 EN ISO 17632-B T49 0 T1-0 CA-U	F, H-Fil	CO <sub>2</sub>	DC(+)	0.04	0.41	1.25	0.014	0.011	-	-	-	510	550	29	50 (-20°C)	KX-200 is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Wire is a metal type of flux cored wire for flat and horizontal position welding. It has good porosity resistance and is applicable for fillet welding of inorganic zinc-primer coated steels.	ABS, BV, DNV, GL, LR, NK, KR, CCS, CE, KS, JIS

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)		
KX-200H	1.2~1.6	AWS A5.20 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B E70T-1C T49 2 T1-0 CA-U YFW- C502M T46 2 R C 4 T49 2 T1-0 CA-U	F, H-Fil	CO <sub>2</sub>	DC(+)	0.04	0.56	1.61	0.013	0.010	-	-	-	517	610	28	70 (-20°C)	KX-200H is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. 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	ABS, BV, DNV, GL, LR, KR, CE, KS, JIS
KX-200UH	1.2~1.6	AWS A5.20 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B E71T-1C T49 4 T1-0 CA-U YFW- C504M T46 2 R C 4 T49 4 T1-0 CA-U	F, H-Fil	CO <sub>2</sub>	DC(+)	0.04	0.45	1.40	0.013	0.010	-	0.41	-	540	610	28	100 (-20°C)	KX-200UH is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Wire is a metal type of flux cored wire for flat and horizontal position welding. It has good porosity resistance and intended for semi-automatic, automatic, single-and multi pass welding.	-
KX-70CM	1.2~1.6	AWS A5.18 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B E70C-3M T49 2 T15-0 M A YFW- A50DM T46 M M 4 T49 T15-0 M A	F, H-Fil	Ar+20%CO <sub>2</sub>	DC(+)	0.03	0.40	1.60	0.014	0.010	-	-	-	480	540	29	55 (-20°C)	KX-70CM is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Wire is a metal type of flux cored wire for flat and horizontal position welding.	ABS, BV, DNV, GL, LR, KR, CE, KS, JIS
KX-706M	1.2~1.6	AWS A5.18 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B E70C-6M T49 3 T15-0 M A YFW- A502M T46 2 M M 4 T49 3 T15-0 M A	F, H-Fil	Ar+20%CO <sub>2</sub>	DC(+)	0.04	0.60	1.50	0.014	0.010	-	-	-	480	540	29	55 (-30°C)	KX-706M is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Wire is a metal type of flux cored wire for flat and horizontal position welding. It features good penetration, good wetting behaviour as well as low hydrogen contents.	ABS, BV, DNV, GL, LR, CE, KS, JIS
KX-706MU	1.2~1.6	AWS A5.18 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B E70C-6M T49 3 T15-0 M A YFW- A503M T46 2 M M 4 T49 3 T15-0 MA-U	F, H-Fil	Ar+20%CO <sub>2</sub>	DC(+)	0.04	0.60	1.50	0.014	0.010	-	-	-	480	540	28	70 (-30°C)	KX-706MU is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Wire is a metal type of flux cored wire for flat and horizontal position welding. It features good penetration, good wetting behaviour as well as low hydrogen contents.	-

NOCKERS  
ENGINEERING PRODUCTS