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NOCKERS
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FLUX CORE WIRES FOR ATMOSPHERIC CORROSION RESISTING STEEL

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	Cu	Mo	Y.S (MPa)	T.S (MPa)	EI. (%)	I.V (J)		
K-71TW	1.2~1.6	AWS A5.29 JIS Z 3320 KS D7109 EN ISO 17632-B E81T1-W2C YFA-50W YFA-50W T49 3 T1- 1CA-NCC1	F,V,OH, H,VD	CO ₂	DC(+)	0.05	0.54	1.10	0.018	0.010	0.55	0.42	0.45	510	590	21	40 (-30°C)	Butt and fillet welding of carbon and 490MPa class high tensile strength weatherproof steel.	-
K-81TW	1.2~1.6	AWS A5.29 JIS Z 3320 KS D7109 EN ISO 17632-B E81T1-W2C YFA-58W YFA-58W T55 3 T1- 1CA-NCC1	F,V,OH, H,VD	CO ₂	DC(+)	0.05	0.44	1.19	0.020	0.010	0.48	0.45	0.55	550	630	28	60 (-30°C)	Butt and fillet of high tensile strength weatherproof steel, for example ASTM-242 or A-588, which is used normally without painting, for shipbuilding and bridges etc.	CE

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