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**FLUX CORE WIRES FOR HIGH TENSILE STRENGTH STEEL (520MPa)**

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-55T	1.2~1.6	AWS A5.29 JIS Z3313 EN ISO 17632-A EN ISO 17632-B	E81T1-GC T55 0 T1-1 CA-U T46 0 P C 1 T55 2 T1-1 CA	F,V,OH, H,VD	CO <sub>2</sub>	DC(+)	0.04	0.54	1.50	0.013	0.010	-	0.41	-	480	540	29	45 (-20°C)	K-55T is designed for welding of 520MPa high tensile steel with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.	CE, JIS
KX-55	1.2~1.6	AWS A5.29 JIS Z3313 EN ISO 17632-A EN ISO 17632-B	E80T1-GC T55 0 T1-0 CA-U T46 0 R C 4 T55 2 T15-0 CA	F, H-Fil	CO <sub>2</sub>	DC(+)	0.03	0.54	1.57	0.014	0.010	-	0.41	-	540	630	26	60 (-20°C)	KX-55 is designed for welding of 520MPa high tensile steel with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.	CE, JIS