

7 Buccleuch Avenue,
 Craighall Park,
 Johannesburg, 2196,
 South Africa



NOCKERS
 ENGINEERING PRODUCTS

+ 27 11 447 8562
 sales@nockers.co.za
 www.nockers.co.za

SELF-SHIELDED 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	Al	Mo	Y.S (MPa)	T.S (MPa)	EI. (%)	I.V (J)			
K-NGS4	1.6~3.2	AWS A5.20 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B	E70T-4 T49 T4-0 N A YFW-S50GB T42 Z Y N 4 T49 Z T4-0NA	F, H-Fil	-	DC(+)	0.17	0.22	0.80	0.012	0.011	-	1.32	-	460	540	23	-	K-NGS4 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.	CE, JIS
K-NGS10	1.6~3.2	AWS A5.20 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B	E70T-10 T49 T10-0 N S-G YFW-S50GB T42 Z V N 4 T49 Z T10-1NS	F, H-Fil	-	DC(-)	0.10	0.11	0.53	0.015	0.009	-	1.10	-	480	530	2	-	K-NGS10 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.	JIS
K-NGS11	0.9~1.6	AWS A5.20 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B	E71T-11 T49 T11-1 N A YFW-S50GB T42 Z Y N 1 T49 Z T11-1NA	F,V,OH, H,VD	-	DC(-)	0.10	0.10	0.55	0.015	0.010	-	1.21	-	500	530	23	-	K-NGS11 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.	CE, JIS
K-NGS	0.9~1.6	AWS A5.20 JIS Z3313 KS D7104 EN ISO 17632-A EN ISO 17632-B	E71T-GS T49 TG-1 N S-G YFW-S50GB T42 Z V N 1 T49 Z TG-1NS	F, H-Fil	-	DC(-)	0.10	0.10	0.55	0.014	0.012	-	1.21	-	480	520	22	-	K-NGS 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.	CE, JIS