

Flux Cored Welding Wire

KX-706T

For 490MPa high tensile steel (Non slag type)

■ Classifications

EN ISO 17632-A:2016 : T42 2 M M21 1 H5

AWS A5.18-15 : E70C-6M

EN ISO 17632-B:2016 : T49 3 T15-1M21A H5

AWS A5.36-15 : E71T15-M21A3-CS1-H4

JIS Z 3313 : T49 3 T15-1MA H5

■ Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, and general fabrications
- Wire is a metal type of flux cored wire for all positional welding
- It feature good penetration, high resistance to porosity, good wetting behaviour as well as low hydrogen contents
- KX-706T is intended for semi-automatic, automatic, single- and multiple pass welding

■ Welding position



■ Polarity & shielding gas

- Mix: Ar+20% CO₂ (15~25 l /min)
- DCEP (DC+)

■ Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
AWS A5.18	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03
KX-706T	0.05	0.39	1.54	0.01	0.01

■ Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Shielding Gas
				-20℃	-30℃	
AWS A5.18	min. 400	min. 480	min. 22		≥ 27	
Example	459	587	28.8	65	48	Mix

■ Notes on usage and welding condition

Dia. (mm)	Amps	Volts
1.2	160 ~ 300	21 ~ 34
1.4	180 ~ 350	21 ~ 37

■ Package

Dia. (mm)		1.2	1.4
		Spool	(kg)
Pailpack	(kg)	100 ~ 300	