

KC-29

For mild steel and 490MPa tensile strength steel

Classifications

EN ISO 14341-A:2008	: G 46 4 C G4Si1	AWS A5.18-05	: ER70S-6
	: G 46 4 M G4Si1	JIS Z 3312	: G 55 A 4U C G6
EN ISO 14341-B:2008	: G 49A 4U C G6		
	: G 49A 4U M G6		

Description

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Served as both carbon dioxide and mixture gas, and stable arc performance in almost welding current
- A wide range of use due to low spatter and all welding position
- Suited for application of sheet metal on high welding current without burn through

Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.08	0.99	1.63	0.015	0.007

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-40°C	
AWS A5.18	min. 400	min. 480	min. 22	≥ 27		CO ₂
EN ISO 14341-A	min. 460	530~680	min. 20		≥ 47	CO ₂
Example	510	620	27	110	105	CO ₂
	560	660	24	90	80	Mix

Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	50 ~ 180	100 ~ 250
	Overhead (PE/4G)	50 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- CO₂: 100% CO₂
- Mix : Ar+20% CO₂ (15~25ℓ /min.)