

ZO-26

For mild steel and 490MPa tensile strength steel

Classifications

EN ISO 14341-A:2008	: G 46 2 C G0	AWS A5.18-05	: ER70S-G
	: G 46 2 M G0	KS D 7025	: YGW11
EN ISO 14341-B:2008	: G 49A 2 C G11	JIS Z 3312	: YGW11
	: G 49A 2 M G11		

Description

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Excellent defect resistant on high heat input
- Possible to achieve higher productivity due to low spatter and deep penetration
- Beautiful weld appearance on flat or horizontal welding position

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ti
0.06	0.80	1.53	0.014	0.010	0.18

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20°C	Remarks
AWS A5.18	min. 400	min. 480	min. 22		
EN ISO 14341-B	min. 390	490~670	min. 18	≥ 27	CO ₂
Example	490	570	30	110	CO ₂
	520	590	31	120	Mix

Operating data

	Dia.(mm)	1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	70 ~ 200	100 ~ 250
	Overhead (PE/4G)	70 ~ 200	100 ~ 250

Polarity and Shielding gas

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

Approvals

Shielding gas	ABS	BV	DNV	GL	LR	KR	NK
CO ₂	3YSA	SA3YM	III YMS	3YS	3YS H15	RSW53G	KSW53G

* Others : KS, JIS