

K-NGS8

For 490MPa high tensile steel (self-shielded, multi-pass)

Classifications

EN ISO 17632-B:2016	: T49 3 T8-1NOA
JIS Z 3313-2009:	: T49 3 T7-1NA
AWS A5.20-2005	: E71T-8
AWS A5.36-2016	: E71T8-A2-CS3-H8
KS D 7104-2012	: YFL-S503B

Description

- For 490MPa high tensile steel and self-shielded wire to facilitate outdoor conditions
- For single and multi-pass welding in all positions
- It has good arc stability, low spatter generation, high efficiency, good bead shape and easy slag removal
- The welding polarity is DCEN (wire negative)

Welding positions



Polarity

- DCEN (DC-)

Typical chemical composition of all-weld metal (%)

Shielding Gas	C	Si	Mn	P	S	Al
None	0.04	0.17	0.81	0.010	0.010	0.68

Typical mechanical properties of all-weld metal

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J) -30°C
AWS A5.20	Min. 390	490-670	Min. 22	≥ 27
EN ISO 17632-B	Min. 390	490-670	Min. 18	≥ 27
Example	410	508	27	67

Notes on usage and welding condition

- Self-shielded FCW generates more fumes than titania type FCW
Ventilation system to be used in small and confined spaces
- To prevent cracking at low temperatures, preheat and maintain Interpass temperatures at 100-200 °C

Package

Diameter (mm)	1.4, 1.6, 2.0, 2.4
Spool (kg)	15, 20
Coil (kg)	20, 25, 30

Operating data

Diameter	(mm)	1.4	1.6	2.0	2.4
Amperage (A)	F (PA/1G)	220-240	260-280	280-300	300-320
	HF (PC/2G)	22-23	23-24	23-24	24-25