

KC-28

For mild steel and 490MPa tensile strength steel

Classifications

EN ISO 14341-A:2008	: G 42 2 C G3Si1	AWS A5.18-05	: ER70S-6
	: G 42 3 M G3Si1	KS D 7025	: YGW12
EN ISO 14341	: G 49A 3 C G6	JIS Z 3312	: YGW12
	: G 49A 3 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 all 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

Welding positions



Polarity & shielding gas

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

Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.07	0.86	1.53	0.012	0.007

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) -30 °C	Remarks
AWS A5.18	Min. 400	Min. 480	Min. 22	≥ 27	CO ₂
EN ISO 14341-A	Min. 420	500-640	Min. 20	≥ 47	CO ₂
Example	450	550	30	70	CO ₂
	480	580	28	80	Mix

Operating data

Diameter (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

Approvals

Shielding gas	ABS	BV	DNVGL	LR	KR	NK
CO ₂	3SA	SA3YM	III YMS	3YS H15	3YSG	KSW53G
Mix	3YSA	-	-	-	-	-

*Others: CCS, RS, CWB, KS, JIS