

**Classifications**

EN ISO 17632-A:2008	: T50 3 1Ni P C 1 H5	AWS A5.29-10	: E81T1-Ni1C
EN ISO 17632-B:2008	: T55 4 T1-1CA-N2 H5	AWS A5.36-12	: E81T1-C1A2-Ni1-H4
JIS Z 3313	: T57 4 T1-1CAP-N2 H5	KS D 7104	: YFW-C602R

**Description**

- It is designed for welding of 560MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a titania type of flux cored wire for all-position welding with 1.0% Ni component
- It provide good wet-in capabilities along with high impact values at low temperatures (-40°C)

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

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

Shielding gas	C	Si	Mn	P	S	Ni
CO <sub>2</sub>	0.02	0.51	1.28	0.014	0.011	1.04

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.29	min. 470	550~690	min. 19		≥ 27	
EN ISO 17632-B	min. 460	550~740	min. 17		≥ 27	
Example	580	630	28	75	50	CO <sub>2</sub>

**Notes on usage and welding condition**

- Refer to page 211~213 for more information on usage
- In case of heavy plate welding, preheat and maintain interpass temperature at 100~200°C in order to prevent crack at low temperatures

**Package**

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		

**Approvals**

Shielding gas	ABS	BV	DNV	LR	NK	KR	RS
CO <sub>2</sub>	4YSAH5	4YSH5	IVYMS(H5)	4YSH5	KSW54GH5	4YSGH5	4YS,H5