

KC-25M

For mild steel and 490MPa tensile strength steel

Classifications

EN ISO 14341-A:2008	: G 42 2 M G2Si1
EN ISO 14341-B:2008	: G 49A 2 M G3
AWS A5.18-05	: ER70S-3
KS D 7025	: YGW16
JIS Z 3312	: YGW16

Description

- For butt and fillet welding of shipbuilding, bridges, structural steel, steel buildings, machineries and vehicles
- Suited for application of sheet metal with mixture gas and all welding positions
- Low slag formation, high deposition rate and superior arc stability

Welding positions



Polarity & shielding gas

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

Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.07	0.67	1.20	0.015	0.011

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	Remarks
	(MPa)	(MPa)	(%)	-30 °C	
AWS A5.18	Min. 400	Min. 480	Min. 22	≥ 27	CO ₂
EN ISO 14341-A	Min. 420	500-640	Min. 20	≥ 47	Mix
Example	440	540	30	100	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