

Flux Cored Wire for High Tensile Strength Steel

KFX-715

Shielding Gas: CO₂

Classification

AWS	A5.20	E71T-5C
JIS	Z3313	T493T5-1CA
EN	17632-A	T 42 X B X
GB	T 10045	E501T-5

Applications and Features

- (1) KFX-715 is suitable for welding 490N/mm² grade steel.
- (2) It is capable of producing low diffusible hydrogen levels.
- (3) It is also ideal for welding in ship-building, structural fabrication and machinery.

Welding Position

All Positions

Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.048	0.34	1.44	0.012	0.013

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch	
			°C	J (kgf -m)
559 (57.0)	506 (51.6)	24	-29	127(13.0)
			-40	115(11.7)

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Amp	F	120~300	150~400	180~450
	H-fillet	120~300	150~350	180~400
	V-up	120~200	150~320	180~240
	H	120~280	150~320	180~350
	V-down	200~260	220~270	230~280