



KISWEL

KISWEL KX-706M

Classifications:

EN ISO 17632-A: T46 2 M M21 3 H5
EN ISO 17632-B: T49 3 T15-0 M21 H5
AWS A5.18: E70C-6M

KS D 7104: YFW-A502M
JIS Z 3313: T49 3 T15-0MA H5

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	P	S	Cu
<0.12	<0.90	<1.75	<0.03	<0.03	<0.50

Description:

- Metal Cored Wire designed for welding of 490MPa high tensile steel with outstanding mechanical properties.
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.
- The said wire has good penetration, high resistance to porosity, good wetting behaviour as well as low hydrogen contents.
- KX-706M is intended for semi-automatic, automatic, single- and multiple pass welding.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 400	min. 480	min. 22	55 (-30°C)

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	Ar + 20%CO ₂	160	300	24	32



ENAR WELD BRAZE PVT. LTD, Enar Chambers, A-112, DDA INDUSTRIAL SHEDS, OKHLA INDUSTRIAL AREA, PHASE - II, NEW DELHI – 110020 ☎ : 011-26383911 /12 /13 Fax : 011-26383913 e-mail : info@enarweld.com

Exclusive Distributors of Kisel Ltd. Korea