K-NGS8

SELF SHIELDED FLUX CORED ARC WELDING CONSUMABLE FOR WELDING OF MILD 490MPa GRADE HIGH TENSILE STEEL

KISWEL

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Description & Application

- **For 490MPa high tensile steel & self-shielded wire to facilitate welding outdoors.**
- **For single and multiple-pass welding in all positions.**
- **It has good arc stability, low spatter generation, high efficiency, good bead shape and slag removal.**
- **The using polarity is DCEN. (wire negative)**

Classification

- **AWS A5.20 : E71T-8 H8**
- **AWS A5.36 : E71T8-A2-CS3-H8**
- **EN ISO 17632 B : T49 3 T8-1NOA**

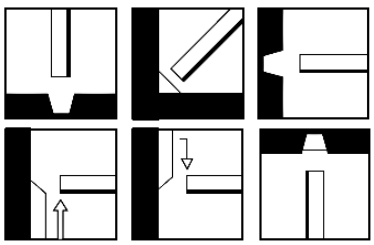
Typical Chemical Composition of Weld Metal(%)

Item	C	Si	Mn	P	S	Ni
AWS A5.20 E71T-8 H8	≤0.30	≤0.60	≤1.75	≤0.03	≤0.03	≤0.50
K-NGS8	**0.04**	**0.55**	**1.25**	**0.015**	**0.011**	**0.38**

Shielding Gas

- **Non gas**

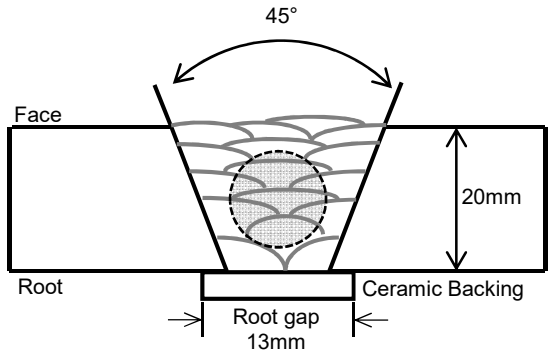
Welding position



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All Weld Metal Test Specimen



Base metal	EH-36
Diameter	1.6 mm
Welding position	1G
Welding current(A)	250
Arc voltage(V)	22

Typical Mechanical Properties of Weld Metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) (Joule @ Temp)	Shielding Gas	PWHT
AWS E71T-8	Min.390	490-670	Min.22	≥ 27 @ -30℃	Non gas	AW
K-NGS8	**420**	**520**	**33**	**67-78 @-30℃**	Non gas	**AW**

Typical Operating Procedures

Dia (mm)	Welding Conditions		Feed speed (m/min)	Deposition Efficiency(%)	Melt-off Rate (Kg/Hr)
	Current (amps)	Voltage (volts)			
1.6	170	19	27.5	73-77	1.7
	250	21	44.0	73-77	2.6
2.0	170	19	26.0	79-81	1.9
	250	21	42.5	79-81	2.8
	350	24	72.0	79-81	4.8
2.4	170	19	22.0	79-81	1.6
	250	21	34.5	79-81	2.7
	350	24	54.0	79-81	4.5

■ Bead appearance

Welding Condition	Horizontal Fillet (1F)
300A/27V	
Welding Condition	**Vertical-up (3F)**
200A/21V	
Welding Condition	**Vertical-down (3F)**
200A/20V	
Welding Condition	**Overhead (4F)**
180A/19V	

Packaging



Size and Weight

Dia. (mm)	1.6, 2.0, 2.4
Weight (kg)	5, 12.5, 15, 20

Approval

■ Handling and Storage

- **Once Flux cored wire picked up moisture, it cannot be dried at high temperature, unlike covered electrode.**
- **If a wire was left in a wire feeder in a high-temperature high- humidity atmosphere in summer season, a wet environment in rainy season or a dew fall environment at night in winter was unpacked, the wire should be kept in an area of low humidity.**

  ※ Temp. below 30℃ relative humidity below 60%

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