KC-35

SOLID WELDING WIRE
FOR 490MPa GRADE STEEL

KISWEL

Rev.0

■ Description & Application

- **The amount of slag generated is reduced by more than 50% compared to conventional products.**
- **It is recommended to use high Ar content in order to prevent slag from oxygen in shielding gas.**
- **Slag concentrates in the crater and is rarely formed in other area**
- **Wide and Beautiful weld appearance on Flat or Horizontal welding position**
  - **Automotive, Electronic products, Thin plate welding parts**

■ Classification

- **AWS A5.18-2005 : ER70S-3**
- **KS D 7025-2005 : YGW14**
- **JIS Z 3312-2009 : G 43 A 2 U M 3**
- **EN ISO 14341-A : G 42 2 M21 2Si1**
- **EN ISO 14341-B : G 49 A 2 M21 S3**

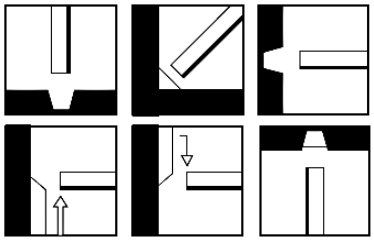
■ Typical Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Cu
AWS ER70S-3	0.06-0.15	0.45-0.75	0.90-1.40	≤0.025	≤0.035	≤0.50
EN ISO 2Si1	0.06-0.14	0.50-0.80	0.90-1.30	≤0.025	≤0.025	≤0.35
KC-35	**0.06**	**0.50**	**1.10**	**0.010**	**0.018**	**0.10-0.35**

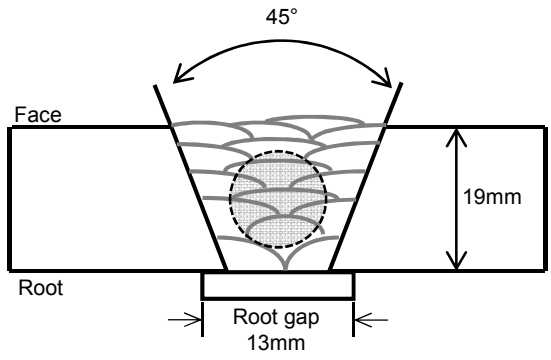
■ Shielding Gas

- **Ar + 5 ~ 15%CO_2**
- **Ar + 15 ~ 25%CO_2 (15~25ℓ/min)**

■ Welding Position



All Weld Metal Test Specimen



Base metal	A515 Gr.70
Diameter	1.2mm
Current / Voltage	280A / 30V
Stick out	20mm
Travel Speed	30 CPM
Welding Position	PA / 1G

Typical Mechanical Properties of Weld Metal

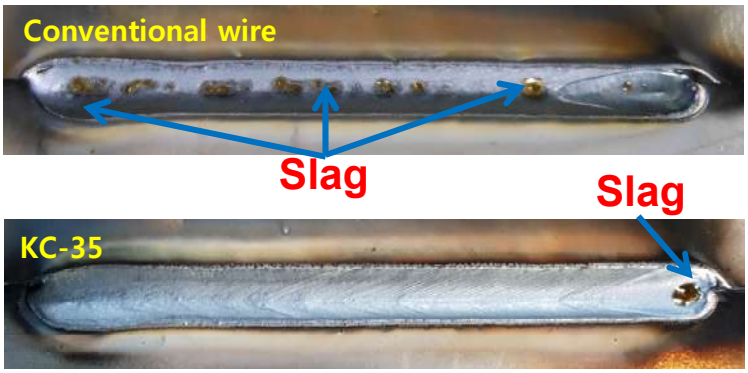
	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) (Joule @ Temp)	Shielding Gas	PWHT
AWS ER70S-3	≥ 400	≥ 480	≥ 22	≥ 27 @ -20℃	-	AW
EN ISO 2Si1	≥ 420	500~640	≥ 20	≥ 47 @ -20℃	-	AW
KC-35	**480**	**550**	**25**	**80 @ -20℃**	**Ar + 10%CO_2**	**AW**
KC-35	**485**	**560**	**25**	**70 @ -20℃**	**Ar + 20%CO_2**	**AW**

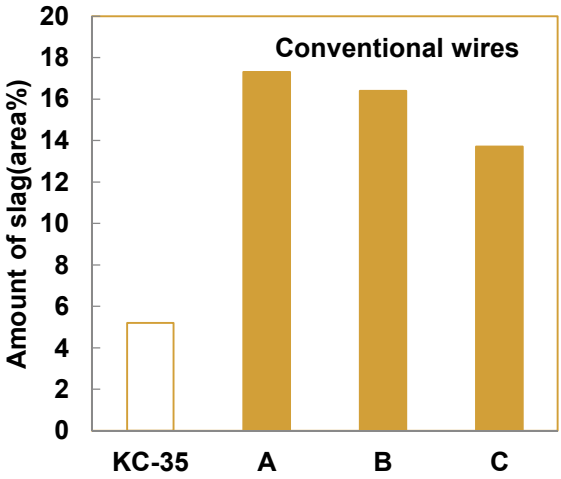
Typical Operating Procedures

Dia (mm)	Shielding Gas	Current (amps)	Voltage (volts)	Feed speed (m/min)	Melt-off Rate (Kg/Hrs)
0.9	Ar + 10% CO_2	190-280	24-30	9.5-15.5	2.4-4.2
1.2	Ar + 10% CO_2	280-340	27-30	8.5-12.5	4.2-6.2
1.4	Ar + 10% CO_2	300-440	30-34	7.5-12.5	5.1-8.5
1.6	Ar + 10% CO_2	320-440	28-32	5.5-7.5	4.9-6.7

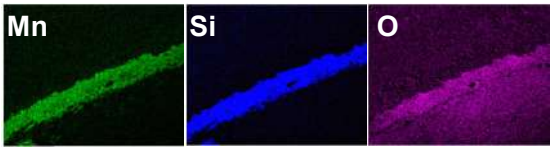
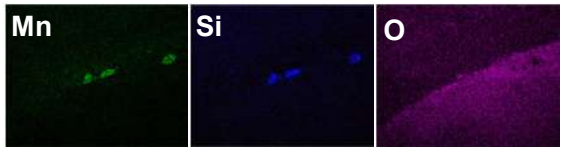
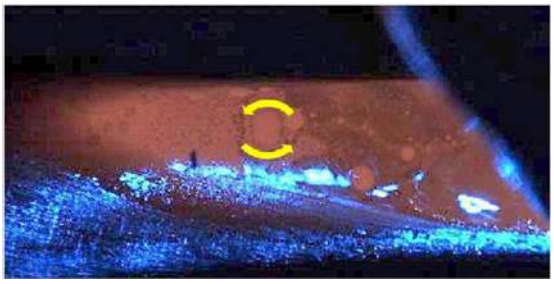
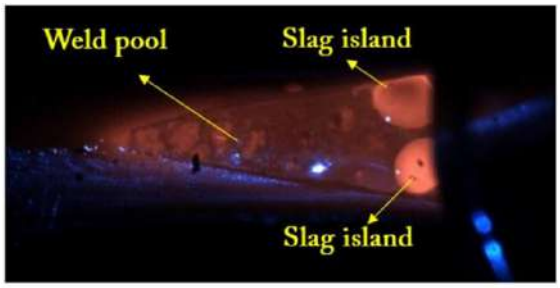
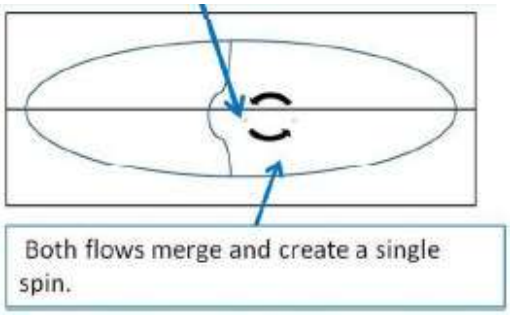
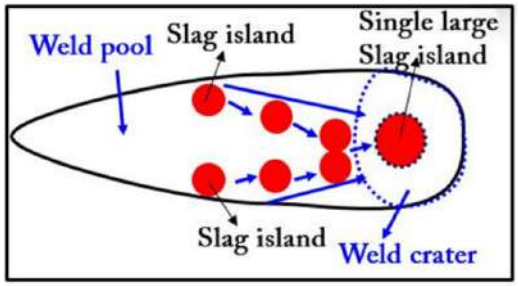
* Polarity : DCEP (DC+)

1. Bead Appearance and Slag amount on galvanized steel





2. Formation of slag

	Conventional	KC-35
Bead		
Content		
Welding Pool		
Slag Behavior		

■ Welding wire feeding

- **Welding wire is fed by feed system**
- **If feeding is not stable, the arc length is changed. It makes problems.**
- **A stable feeding requires the proper configuration of the welding system and the selection of the product with the appropriate level of surface roughness**

■ Wire feed system

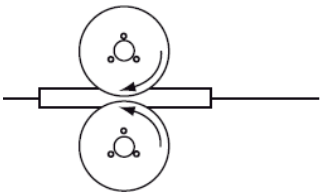


Push system for normal GMAW wire

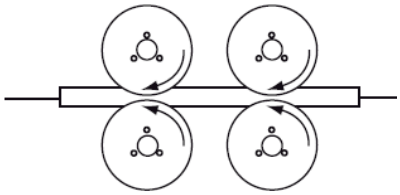


Push/Pull system for soft GMAW wire (Aluminum)

■ Drive rollers

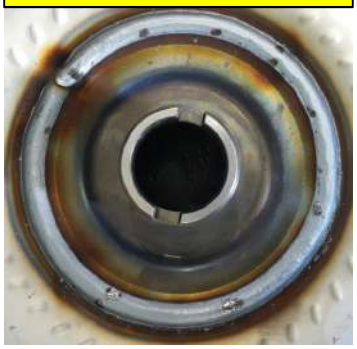


Two roll feeder



Four roll feeder

■ Bead appearance (Slag distribution by Mix gas type)

Conventional (Slag 11.81%)	KC-35 Ar+20%CO2 (Slag 5.30%)	KC-35 Ar+15%CO2 (Slag 2.59%)	KC-35 Ar+10%CO2 (Slag 2.22%)
			

※ It is recommended to use high Ar content in order to prevent slag from oxygen in shielding gas.

■ Packaging



■ Size and Weight

Dia. (mm)	0.8, 0.9, 1.0, 1.14, 1.2, 1.32, 1.4			
Weight (kg)	2	5	12.5, 15, 20	100~450
Packaging	Plastic Spool			Pail-pack / DPP
	-		Wire Basket	

■ Approval

Shielding gas	ABS	BV	DNV GL	LR	KR	NK
CO2	-	-	-	-	-	-
MIX	-	-	-	-	-	-

■ Handling

- **Do not speed up or brake loaded products to prevent rollover during transport.**
- **Please run out product within two weeks of its packaging release.**
- **If the product is discontinued for more than two weeks, it should be packed and stored separately to prevent air contact.**
- **Products that are in use on the supply line must be prevented by covering to prevent product contamination and electric shock accidents.**
- **When using Drum or DPP, check the enclosed installation and handling manual, and use it after proper installation.**

■ Storage

- **Do not stock Drum or DPP packaging palettes more than 2 layers and Spool or Wire basket packaging palettes more than 3 layers. To prevent damage to the products and external packaging.**
- **Store the product without removing the packaging to prevent air contact.**
- **To prevent product packaging damage and condensation due to moisture. Keep the product at a relative humidity of less than 50%.**

KISWEL

The Management System of KISWEL LTD, 704, Gongdan-ro, Seongsan-gu, Changwon-si, Gyeongnam 51544, Republic of Korea, 70, Saebyeok-ro 63beon-gil, Sasang-gu, Busan 47018, Republic of Korea has been approved by Lloyd's Register Quality Assurance to : IATF 16949:2016, ISO 14001:2015, applicable to : Manufacture of solid welding wires & rods, flux cored wires, submerged arc welding wires & fluxes, stainless steel welding wires & rods and covered electrodes.
More information : www.kiswel.com

