ZO-60

For 590MPa tensile strength steel

Classifications

EN ISO 16834-A:2007	: G 55 2 C Z	KS D 7025	: YGW21
EN ISO 16834-B:2007	: G 62A 2 U C 3M1T	JIS Z 3312	: G 59J A 1 U C 3M1T
AWS A5.28-05	: ER80S-G		

Description

- For butt and fillet welding of machineries, heavy equipments, pressure vessels and steel that demand for creep-resistant in high temperature
- Superior arc stability and X-ray soundness
- Stable weldability on high welding current
- Beautiful weld appearance due to low spatter

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Mo	Ti
0.07	0.84	1.95	0.014	0.005	0.31	0.17

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -5℃	IV (J) -20℃	Remarks
AWS A5.18		min. 550				
EN ISO 16834-B	min. 530	620~820	min. 15		≥ 47	CO_2
Example	550	640	27	120	110	CO_2

Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400
	Vertical (PF/3G)	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- CO_2 : 100% CO_2 (15~25ℓ /min.)

Approvals

Shielding gas	NK
CO_2	KSW3Y46G

* Others: JIS