

CSF-91K2

For 620N/mm² class high strength steel
and low temperature steel

AWS	A5.29	E91T1-K2C
KS	D 7104	YFW-C602R
JIS	Z3313	T622T1-1CA-N3-H5

Applications

Butt, fillet welding of 620N/mm² class high strength steel and low temperature steel of structure such as ships, bridges, buildings and storage tanks etc.

Characteristics

- (1) CSF-91K2 is a titania type flux cored wire and designed for all-position welding by single pass & multi pass with CO₂ gas shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) It provides excellent impact value at low temperatures down to -20°C.

Notes on usage

- (1) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

Typical chemical composition of weld metal (%)

(Shielding gas : 100%CO₂)

C	Mn	Si	P	S	Ni	Mo
0.05	1.35	0.30	0.011	0.009	1.52	0.10

Typical mechanical properties of weld metal

(Shielding gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
			-20°C	-30°C
596	670	26.0	135	94

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)
Amp.	F & H-F	180~340	200~360
	V-up	120~220	140~260
	V-down	120~240	140~260
	OH	120~220	140~260