

For Mild Steel and 490MPa High Tensile Strength Steel

APPLICATIONS

Welding of mild steel and 490MPa high tensile strength steel for automobiles, rolling stock, machinery, air conditioners and light steel frames.

CHARACTERISTICS

YM-TX is a gas metal arc welding wire to be used with Ar+CO₂ shield gas. As the slag volume is extremely low on the welding bead, the weld parts have excellent electrodeposition coating ability. Arc is stable, spatters are few, weldability is satisfactory and bead shape is flat. Weld metal shows excellent toughness and can be applied to high tensile steel sheets for automotive. It is possible to short-circuit the transfer weld with a low current. It assures excellent weldability and properties of weld metal in pulsed arc welding.

GUIDELINES FOR USAGE

1. The spray arc in the high current range and short circuit arc in the low current range are applicable. Excellent weldability and mechanical properties are also obtained in the pulse welding.
2. It should be applied that the shielding gas is Ar-5~25CO₂.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S
0.11	0.01	1.21	0.006	0.007

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch J	
			-40°C	-20°C
460	540	27	154	163

■ SIZES & RECOMMENDED CURRENT RANGE<DC(+)>

Diameter (mm)		1.0	1.2	1.4
Current range A	F, H-Fil	70~250	80~400	150~400
	H	70~250	80~400	—