

# NK-59

Class of: AWS A5.18 ER70S-6  
JIS Z 3312 YGW12**For welding mild steel and 50 kg/mm<sup>2</sup> class high tensile steel**

## DESCRIPTION

NK-59 is a solid wire which has been designed to get good usability and are intended for both single and multipass welding. Copper coating ensures problem free wire feeding, smooth current pick-up and minimal contact tip wire. They are especially suited for sheet metal applications, where smooth weld beads are desired and structural and plate steels with high deposition recovery up to 95%.

## APPLICATIONS

For butt and fillet welding of structural steels, and general fabrication such as pressure vessel plates, carbon steel, for intermediate and higher temperature service, or for moderate and lower temperature service.

## TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	S	P	Mn	Cu	Shielding Gas
0.08	0.81	0.019	0.015	1.41	0.01	CO <sub>2</sub>

## TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength	Tensile Strength	Elongation	Charpy Impact Value (-29°C)
471 N/mm <sup>2</sup> 48.06 kgf/mm <sup>2</sup>	579 N/mm <sup>2</sup> 59.08 kgf/mm <sup>2</sup>	29.0%	80 Joule 8.16 kgf-m

## RECOMMENDED CURRENTS: DCEP

Diameter (mm)	1.0	1.2
Current Range (Amp.)	80 ~ 250	100 ~ 350
Voltage Range (Volt)	18 ~ 32	18 ~ 34

## PACKAGE

Diameter (mm)	Weight in cartons (kgs)
1.0 ; 1.2	250