

# ESW Wire & Flux

## YF-15I × PS-56

AWS A5.25M FES482-ES-G-EW  
A5.25 FES70-ES-G-EW  
JIS Z 3353 YES411-S

### Product Features:

- Electro Slag Welding (SESNET) wire and flux combination for low carbon 490 N/mm<sup>2</sup> steel.
- Fused type flux combined with low alloy wire with Mn, Mo content.
- High efficiency for vertical riser welding of thick base metal
- Fused type flux of NSSW achieve higher mechanical properties and performance.

### Applications:

- Suitable for welding of 490 N/mm<sup>2</sup> high tensile Strength steel structures, shipbuilding, bridge structures.

Typical chemical composition of Wire (wt%)

C	Si	Mn	Mo	Fe
0.05	0.57	1.62	0.17	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-20°C) J
518	619	24	83

Size & recommended welding Parameters

Diameter	1.6mm
Polarity	DC+
Ampere	300~450

- Note:**
1. Keep groove gap between 24+/-4mm
  2. Wire extension length: 30~40mm, slag thickness: 15~20mm

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