

ESW Wire & Flux

YF-15I × PS-66

AWS A5.25M FES552-ES-G-EW
A5.25 FES80-ES-G-EW
JIS Z 3353 YES501-S

Product Features:

- Electro Slag Welding (SESNET) wire and flux combination for low carbon 550 N/mm² 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 550 N/mm² high tensile Strength steel structures, shipbuilding, bridge structures.

Typical chemical composition of Wire (wt%)

C	Si	Mn	Mo	Fe
0.1	0.55	1.34	0.18	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
505	615	28	56

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

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw