



JQ • YJ501-1

Conform to GB/T 10045-2018 T492T1-1C1A
 Equivalent to AWS A5.36 E71T-1C
 Equivalent to JIS Z3313 T492T1-1CA
 Equivalent to ISO 17632-B-T492T1-1CA

Instructions: JQ.YJ501-1 is titanium-oxide CO₂-shielded flux-cored welding wire, characterized by excellent welding performance, soft and stable arc, low spatter, easy slag removal and beautiful weld joint appearance. It is applicable to downward welding and horizontal welding and allows all-position welding with high welding efficiency. After toughening treatment with microelements, the deposited metal has excellent low temperature toughness, good crack resistance and stable and reliable internal quality.

Purpose: It is applicable to welding of shipbuilding, machinery manufacturing, petroleum machinery, chemical machinery and lifting machinery made of carbon steel and low-alloy structural steel.

Chemical composited metal (%) (shielding gas: CO₂)

Items	C	Mn	Si	S	P
Guarantee value	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.030	≤ 0.030
Measured value	0.05	1.36	0.41	0.008	0.012

Mechanical properties of deposited metal (shielding gas: CO₂)

Items	R _m (MPa)	R _{eL} /R _{p0.2}	A(%)	KV ₂ (J) -20°C
Guarantee value	490 ~ 660	≥ 390	≥ 18	≥ 27
Measured value	560	480	27	145

Diffusible hydrogen content of deposited metal (thermal conductivity method): ≤10ml/100

X-ray radiographic inspection requirements: Level II

Reference current (DC⁺)

Welding wire diameter (mm)		Φ1.0	Φ1.2	Φ1.4	Φ1.6
Current Range (A)	Downward welding	120 ~ 250	120 ~ 300	150 ~ 400	180 ~ 450
	Vertical up welding and over-head welding	120 ~ 210	120 ~ 260	150 ~ 270	180 ~ 280
	Vertical down welding	200 ~ 250	300 ~ 300	220 ~ 300	250 ~ 300
	Horizontal welding	120 ~ 230	120 ~ 280	150 ~ 320	180 ~ 350

Precautions:

1. The workpiece to be welded shall be subject to oil and rust removal.
2. The gas flow during welding is generally 20-25 L/min.
3. When flux-cored welding wires are used for welding, the length of wire extension shall be 15-25mm.
4. The humidity of the welding wire warehouse shall be maintained less than 60%.
5. The storage time of non-vacuum packaged welding wires shall not exceed half a year, and that of vacuum packaged welding wires shall not exceed one year.

Welding position:

