

Submerged Arc Welding Wire KJS - 110

Standards

AWS A5.17

EL12

EN 760

S1

Weld Metal Chemical Analysis (%)

	C	Si	Mn	P	S
Wire (S1)	0.06 - 0.10	Max 0.1	0.35 - 0.5	Max 0.03	Max 0.03
KJS-110 (S1) + KJF - 510	0.04 - 0.06	0.5 - 0.6	0.6 - 0.8	Max 0.03	Max 0.03
KJS-110 (S1) + KJF - 610	0.04 - 0.07	0.2 - 0.3	1.15 - 1.35	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Wire + Flux	U.T.S.	Y.T.S.	EL	Charpy test		
	(Mpa)	(Mpa)	(%)	RT	0 °C	-30°C
KJS - 110 (S1) + KJF - 510	490 - 510	405 - 420	26 - 28	40 - 60	--	--
KJS - 110 (S1) + KJF - 610	500 - 520	415 - 430	26 - 28	75 - 90	--	40 - 50

Wire Diameter and Packing

Packing: In Drum of 350 – 450Kgs, Coil of 25Kgs or Spool of 15Kgs according to below details at customer's option

Packing	Wire Dia (mm)
15Kgs Spool	1.60 - 2.40
25Kgs Coil and Drum	2.40 - 3.20 - 4.0 - 5.0

Advantages

Copper Coated Wire, Suitable for Submerged Arc Welding of Low Alloy and C-Mn Steel
Widely used with KJF-510, KJF-610 for Structural Steels, Poles and Pillars and High Speed Welding.
Current: DCEP/AC