

Submerged Arc Welding Wire KJS - 120

Standards

AWS A5.17

EM12

EN 760

S2

Weld Metal Chemical Analysis (%)

	C	Si	Mn	P	S
Wire (S2)	0.06 - 0.10	Max 0.1	0.85 - 1.05	Max 0.03	Max 0.03
KJS-120 (S2) + KJF - 510	0.04 - 0.06	0.55 - 0.65	1.0 - 1.2	Max 0.03	Max 0.03
KJS-120 (S2) + KJF - 610	0.04 - 0.06	0.25 - 0.35	1.5 - 1.7	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-120 (S2) + KJF - 510	505 - 520	410 - 430	25 - 27	50 - 65	--	30 - 38
KJS-120 (S2) + KJF - 610	480 - 510	420 - 440	25 - 27	80 - 95	--	45 - 55

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 for Structural Steels, Poles and Pillars, and High Speed Welding.
Widely used with KJF-610 for welding tanks, Oil and gas Pipe production and marine industries
Current: DCEP/AC