

Submerged Arc Welding Wire KJS - 122

Standards

AWS A5.17

EM12K

EN 760

S2Si

Weld Metal Chemical Analysis (%)

	C	Si	Mn	P	S
Wire (S2Si)	0.06 - 0.10	0.15 – 0.25	0.85 - 1.05	Max 0.03	Max 0.03
KJS-122 (S2Si) + KJF - 610	0.04 - 0.06	0.35 - 0.45	1.55 - 1.80	Max 0.03	Max 0.03
KJS-122 (S2Si) + KJF - 910	0.04 - 0.06	0.25 - 0.35	0.85 - 1.1	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test		
				RT	-30 °C	-50°C
KJS-122 (S2Si) + KJF - 610	505 - 530	430 - 460	25 - 27	85- 95	40 - 50	---
KJS-122 (S2Si) + KJF – 910(P.W)	505 - 515	415 - 435	26 - 28	110 - 130	55 - 65	30 - 40

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-910 for welding in marine industries

Widely used with KJF-610 for Oil and gas Pipe production

Current: DCEP/AC