

## Submerged Arc Welding Wire KJS - 124

### Standards

**AWS A5.23**

EA2

**EN 760**

S2Mo

### Weld Metal Chemical Analysis ( % )

	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Mo</b>	<b>P</b>	<b>S</b>
<b>Wire ( S2Mo )</b>	0.06 - 0.10	Max 0.10	0.85 - 1.05	0.4-0.5	Max 0.03	Max 0.03
KJS-124 ( S2Mo) + KJF - 610	0.04 - 0.06	0.35 - 0.45	1.55 - 1.75	0.4-0.5	Max 0.03	Max 0.03
KJS-124 ( S2Mo) + KJF - 614	0.04 - 0.06	0.25 - 0.35	1.65 - 1.9	0.4-0.5	Max 0.03	Max 0.03

### Weld Metal Mechanical Properties

<b>Wire + Flux</b>	<b>U.T.S.</b>	<b>Y.T.S.</b>	<b>EL</b>	<b>Charpy test</b>		
	<b>( Mpa)</b>	<b>( Mpa)</b>	<b>(%)</b>	<b>RT</b>	<b>-30 °C</b>	<b>-40°C</b>
KJS-124 ( S2Mo) + KJF - 610	570 - 600	470 - 490	23 - 25	90- 100	45 - 55	40 - 44
KJS-124 ( S2Mo) + KJF - 614	620 - 635	540 - 565	20- 22	65 - 80	40 - 450	30 - 35

### 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

<b>Packing</b>	<b>Wire Dia (mm)</b>
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

Is used with KJF-610 for welding of fine grain steel

Is used with KJF-614 for welding different thickness of gas and oil pipe.

Current: DCEP/AC