

## Submerged Arc Welding Wire KJS - 125

### Standards

AWS A5.23

EN 760

EA4

S3Mo

### Weld Metal Chemical Analysis ( % )

	C	Si	Mn	Mo	P	S
<b>Wire ( S3Mo )</b>	0.07 - 0.10	Max 0.10	1.35- 1.65	0.5-0.6	Max 0.03	Max 0.03
KJS-125 ( S3Mo) + KJF - 910	0.04 - 0.06	0.2 - 0.3	1.2 - 1.4	0.5-0.6	Max 0.03	Max 0.03
KJS-125 ( S3Mo) + KJF - 915	0.05 - 0.08	0.5 - 0.6	1.70 - 1.90	0.5-0.6	Max 0.03	Max 0.03

### Weld Metal Mechanical Properties

Wire + Flux	U.T.S.	Y.T.S.	EL	Charpy test		
	( Mpa)	( Mpa)	(%)	RT	-30 °C	-40°C
KJS-125 ( S3Mo) + KJF - 910	585 - 615	490 - 510	20 - 22	60- 80	35 - 45	---
KJS-125 ( S3Mo) + KJF - 915	640 - 660	550 - 570	19- 21	50 - 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

Suitable for submerged arc welding of a series of steels including Molybdenum, high strength, fine grain and low temperature ones.

Current: DCEP/AC