

Submerged Arc Welding Wire KJS - 126

Standards

AWS A5.23

EH14

EN 760

S4

Weld Metal Chemical Analysis (%)

	C	Si	Mn	P	S
Wire (S4)	0.12 - 0.18	Max 0.10	1.75- 2.2	Max 0.03	Max 0.03
KJS-126 (S4) + KJF - 610	0.05 - 0.07	0.3 - 0.4	1.8 - 2.1	Max 0.03	Max 0.03
KJS-126 (S4) + KJF - 910	0.06 - 0.08	0.2 - 0.3	1.50 - 1.60	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test		
				-40 °C	-50 °C	-60°C
KJS-126 (S4) + KJF – 610 P.W	525 - 540	425 - 440	24 - 26	45- 55	33 - 38	---
KJS-126 (S4) + KJF – 910 P.W	510 - 530	410 - 430	24- 26	---	55 - 65	35 – 45

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.

Ensure appropriate U.T.S and Charpy Index in -60°C by using KJF-610 and KJF-910 and applying heat treatment cycle.

Current: DCEP/AC.