

Submerged Arc Welding Wire KJS - 128

Standards

AWS A5.23

EB2

EN 760

CrMo1

Weld Metal Chemical Analysis (%)

	C	Si	Mn	Mo	Cr	P	S
Wire (S2CrMo1)	0.06 - 0.10	Max 0.10	0.85- 1.05	0.4 – 0.5	1.0- 1.2	Max 0.03	Max 0.03
KJS-128 (S2CrMo1) + KJF - 915	0.06 - 0.08	0.55 - 0.65	1.35- 1.55	0.4- 0.5	1.0-1.2	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	-50°C
KJS-128 (S2CrMo1) + KJF - 915	640 - 670	550 - 560	19 - 21	50- 65	----	---

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 KJS-128 Cr-Mo is suitable for submerged arc welding of low alloy heat and creep resistant as well as fine grain steels having working temperature of higher than 550°C.

Current: DCEP/AC.