

Submerged Arc Welding Wire KJS - 129

Standards

AWS A5.23

EN 760

EG

S2MoTB

Weld Metal Chemical Analysis (%)

	C	Si	Mn	Mo	Ti	B
Wire (S2MoTB)	0.06 - 0.10	Max 0.10	0.85- 1.05	0.4 – 0.5	0.1	+
KJS-129 (S2MoTB) + KJF - 614	0.04 - 0.08	0.25 - 0.40	1.9- 2.1	0.4- 0.5	0.1	+

Weld Metal Mechanical Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test		
				RT	-50 °C	-60°C
KJS-129 (S2MoTB) + KJF - 614	640 - 700	550 - 570	18 - 20	40- 60	----	---

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-129 enjoys Titanium Boron alloy providing highly desirable metallurgical properties and extensively applies to welding and producing large diameter sour gas pipes using KJF-615 and KJF-614.

Current: DCEP/AC.