

Solid Wire For Gas Shielded Arc Welding KJG - 230

Standards:

AWS A5.18
ER70S - 6

DIN 8559
SG3

EN 440
G4 Si 1

Weld Metal Chemical Analysis (%):

Wire + Shielded Gas	C	Si	Mn	Cu
KJG - 230 + 100 %CO ₂	0.06 - 0.09	0.8 - 1.0	1.60 - 1.75	Max 0.1

Weld Metal Mechanical Properties:

Wire + Shielded Gas	U.T.S. (Mpa)	Y.S. (Mpa)	El %	Charpy Impact ISO – V (J)	
				R.T.	-40°C
KJG - 230 + 100 %CO ₂	550 - 570	445 - 465	23 - 25	45 - 60	35 - 50

Packing and Diameter:

Packing: In Spool according to below details at customer's option

Packing	Wire Dia(mm)
Spool (15 Kg)	0.80 - 1.0 - 1.20 - 1.60
Coil/Drum (25 or 350 to 450 Kg)	3.20 - 4.0

Descriptions:

KJG-230 is GMAW copper coated wire emitting homogenous weld bead suitable for welding heavy metallic structures, shipbuilding, tanks, crane production and vehicle assembly line with no spatter due to the stable arc. Higher weld bead consistency make it more feasible for projects requiring more strength if compared to KJG-220.

Shield Gas: Ar + 20% CO₂ or 100% CO₂

Welding Current: DCEP

Welding positions: Flat, Horizontal, Filet, Upward, Downward,

Overhead KJG-230 is almost equivalent to the followings:

Lincoln Electric NM27

ESAB Autrod 12.64