

Flux Cored Wire For Submerged arc welding KJTUBS - 320

Standard

DIN 8555

UP1 - GF - 300 - T

Typical weld metal chemical composition (weight %)

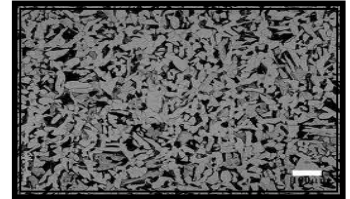
Wire + Flux	C	Si	Mn	Cr	Mo
KJTUBS - 320 + KJF - 920	0.07 - 0.09	0.7 - 1.0	1.8 - 2.1	1.3 - 1.6	0.4 - 0.6

Typical Weld Metal Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test R.T.
KJTUBS - 320 + KJF - 920	830 - 850	750 - 770	18 - 20	40 - 60

Metallurgical Weld Metal Properties

Machinability	Good
Polarity / Current Type	DCEP
Microstructure	Ferrite - Pearlite
Impact resistance	Good
Wire + Flux	KJTUBS - 320 + KJF - 920
Weld metal hardness (HB)	265 - 310



Packing

250Kgs drum or 25 Kgs coil, depending on wire size and customer's order

Welding method	FIFO Technology
Wire Dia. (mm)	2.4,2.80,3.20

Description

Tubular wire is designed for surfacing using submerged arc welding method
The tubular wire provides Suitable creep resistance due to the presence of chromium, molybdenum and low carbon
Suitable for rebuilding Crane wheels, wagon wheels,...