

Tubular Wire For submerged arc welding KJTUBS - 322

Standard

DIN 8555

UP1 - GF - 250 - P

Typical weld metal chemical composition (weight %)

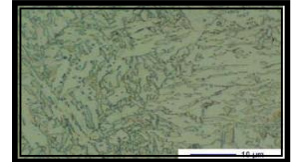
Wire + Flux	C	Si	Mn	Cr	Ni	Mo
KJTUBS - 322 + KJF - 610	0.03 - 0.05	0.2 - 0.3	1.1 - 1.3	1.0 - 1.3	1.8 - 2.0	0.40 - 0.50
KJTUBS - 322 + KJF - 910	0.04 - 0.06	0.15 - 0.2	0.5 - 0.7	1.05 - 1.25	1.8 - 2.1	0.45 - 0.55
KJTUBS - 322 + KJF - 915	0.04 - 0.06	0.4 - 0.7	0.8 - 1.0	1.1 - 1.3	1.8 - 2.1	0.45 - 0.55

Typical Weld Metal Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test R.T.
KJTUBS - 322 + KJF - 610	730 - 750	620 - 640	19 - 21	80 - 100
KJTUBS - 322 + KJF - 910	720 - 740	610 - 630	19 - 21	110 - 130
KJTUBS - 322 + KJF - 915	790 - 820	650 - 670	19 - 21	100 - 120

Metallurgical Weld Metal Properties

Machinability	Good		
Polarity / Current Type	DCEP		
Microstructure	Ferrite - Pearlite		
Impact resistance	Very good associated high-strength		
Wire + Flux	KJTUBS - 322 + KJF - 610	KJTUBS - 322 + KJF - 910	KJTUBS - 322 + KJF - 915
Weld metal hardness (HB)	220 - 240	215 - 235	225 - 250



Packing

250Kgs drum or 15 / 25 Kgs spool/coil, depending on wire size and customer's order

Welding method

FIFO Technology

Wire Dia. (mm)

1.60,2.0,2.4,2.80,3.20

Description

Tubular wire for SAW surfacing

Suitable for buffering especially surfacing Continuous casting rollers