

Tubular Wire For Submerged arc welding KJTUBS - 330

Standard

DIN 8555

UP1 - GF - 350 - P

Typical weld metal chemical composition (weight %)

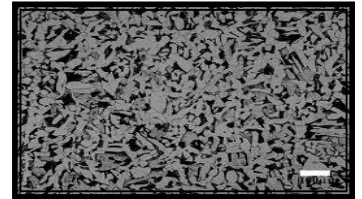
Wire + Flux	C	Si	Mn	Cr	Ni	Mo
KJTUBS - 330+ KJF - 915	0.08- 0.12	0.4 - 0.6	1.2 - 1.4	2.3 - 2.5	3.4 - 3.6	0.50 - 0.70

Typical Weld Metal Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test -30°C
KJTUBS - 330 + KJF - 915	850 - 900	650 - 700	17 - 19	30 - 35

Metallurgical Weld Metal Properties

Machinability	Good
Polarity / Current Type	DCEP
Microstructure	Ferrite - Pearlite
Impact resistance	Very good associated high-strength
Wire + Flux	KJTUBS - 330 + KJF - 915
Weld metal hardness (HRC)	36 - 39



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 containing Cr, Ni, Mo alloys for welding high strength low alloyed steels.
 Preheating temperature required based on equivalent carbon content and work piece thickness
 Suitable for Welding S690 and HSLA steels
 Good Impact resistance (even at -30°C)
 Suitable for road construction equipment, cranes equipment and structures under high tensile stress
 Probable occurrence of lower strength and tenacity in HSLA steels if inter-passing temp exceeds 200°C