

Tubular Wire For Submerged arc welding KJTUBS - 340

Standard

DIN 8555

UP 1 - GF - 350 - G

Typical weld metal chemical composition (weight %)

Wire + Flux	C	Si	Mn	Cr	Mo	Nb
KJTUBS - 340 + KJF - 915	0.11 - 0.13	0.4 - 0.6	1.3 - 1.5	4.1 - 4.3	0.45 - 0.65	0.14 - 0.16

Metallurgical Weld Metal Properties

Machinability	Good
Polarity / Current Type	DCEP
Microstructure	martensitic - Bainite
Metal-to-Metal wear resistance	Good
Impact resistance	Moderate
Wire + Flux	KJTUBS - 340 + KJF - 915
Weld metal hardness (HB)	325 - 375



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 for SAW hardfacing

Suitable for rebuilding and surfacing of axes and similar parts exposed to metal-to-metal wear, such as rollers and bulldozer wheels and road construction machines.