

## Tubular Wire For Submerged arc welding KJTUBS - 414

### Standard

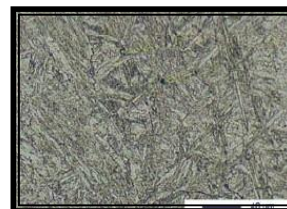
**DIN 8555**  
UP Δ - GF - 40- CG

### Typical weld metal chemical composition (weight %)

| Wire + Flux              | C           | Si        | Mn        | Cr          | Ni        | Mo        |
|--------------------------|-------------|-----------|-----------|-------------|-----------|-----------|
| KJTUBS - 414 + KJF - 915 | 0.05 - 0.07 | 0.6 - 0.8 | 0.7 - 0.9 | 12.5 - 14.0 | 4.0 - 5.0 | 0.9 - 1.2 |

### Metallurgical Weld Metal Properties

|  |                        |
|--|------------------------|
| Machinability                          | Hard                   |
| Polarity / Current Type                | DCEP                   |
| Microstructure                         | Martensitic+10%Ferrite |
| Metal-to-Metal wear resistance         | Good                   |
| Hardness for 5 mm weld Metal thickness |                        |



| Wire + Flux              | As Weld     | 525 °C      | 550 °C      | 575 °C      |
|--------------------------|-------------|-------------|-------------|-------------|
| KJTUBS - 414 + KJF - 915 | 41 - 43 HRC | 38 - 40 HRC | 36 - 38 HRC | 34 - 36 HRC |

### Packing

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

|                |                    |
|----------------|--------------------|
| Welding method | FIFO Technology    |
| Wire Dia. (mm) | 2.40 , 2.80 , 3.20 |

### Description

Tubular wire for submerged arc welding of Martensitic stainless steels and surface coating of continuous casting rollers

Suitable for water corrosion resistance, fatigue and erosion