

## Tubular Wire For Submerged arc welding KJTUBS - 420

### Standard

**DIN 8555**  
UP6 - GF - 50 - C

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

Wire + Flux	C	Si	Mn	Cr
KJTUBS - 420 + KJF - 915	0.25 - 0.35	0.3 - 0.5	0.5 - 0.7	12.0 - 14.0

### Metallurgical Weld Metal Properties

Machinability	Very hard
Polarity / Current Type	DCEP
Microstructure	Martensitic
Metal-to-Metal wear resistance	Very good
Wire + Flux	KJTUBS - 420 + KJF - 915
Weld metal hardness (HRC)	46 - 50



### 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 submerged arc welding of Martensitic stainless steels and surface coating of continuous casting rollers

Suitable for water corrosion resistance, fatigue and erosion