Tubular Wire For Submerged arc welding
KJTUBS - 520

Standard

DIN 8555

UP1 - GF - 300 - P

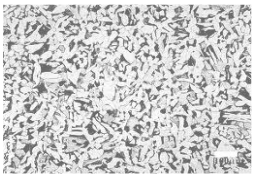
Typical weld metal chemical composition (weight %)

Wire + Flux	C	Si	Mn	Cr	Ni	Mo
KJTUBS - 520 +KJF - 910	0.03 - 0.05	0.3 - 0.5	1.2 - 1.5	0.6 - 0.8	2.3 - 2.6	0.40 - 0.60
KJTUBS - 520 +KJF - 920	0.04 - 0.06	0.5 - 0.6	1.7 - 1.9	0.7 - 0.9	2.4 - 2.7	0.45 - 0.65

Typical Weld Metal Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test R.T.
KJTUBS - 520 + KJF - 910	650 - 710	540 - 580	20 - 22	100 - 115
KJTUBS - 520 + KJF - 920	720 - 750	600 - 620	18 - 20	110 - 125

Metallurgical Weld Metal Properties

Machinability	Good	
Polarity / Current Type	DCEP	
Microstructure	Ferrite + Perlite	
Impact resistance	Good associated high strength	
Wire + Flux	KJTUBS - 520 + KJF - 910	KJTUBS - 520 + KJF - 920
Weld metal hardness (HRC)	24 - 27	29 - 32

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

Suitable for buffer layer for surfacing

Applicable for reconstruction of mobile terrestrial equipment and other heavy steel structures with high tensile strength