

Flux Cored Wire For Submerged arc welding KJTUBS - 525

Standard

DIN 8555

UP5 - GF - 40 - G

Typical weld metal chemical composition (weight %)

Wire + Flux	C	Si	Mn	Cr	Ni	Mo
KJTUBS - 525 + KJF - 910	0.04 - 0.07	0.6 - 0.9	0.7 - 0.9	5.2 - 6.2	0.20 - 0.25	0.40 - 0.60
KJTUBS - 525 + KJF - 915	0.04 - 0.06	0.9 - 1.1	1.0 - 1.2	5.3 - 6.3	0.22 - 0.26	0.45 - 0.65

Typical Weld Metal Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test R.T.
KJTUBS - 525 + KJF - 910	660 - 690	530 - 570	20 - 22	35 - 40
KJTUBS - 525 + KJF - 915	740 - 770	600 - 620	19 - 21	30 - 35

Metallurgical Weld Metal Properties

Machinability	Good
Polarity / Current Type	DCEP
Microstructure	Bainite
Metal-to-Metal wear resistance	Good



Wire + Flux	KJTUBS - 525 + KJF - 910	KJTUBS - 525 + KJF - 915
Weld metal hardness (HRC)	34 - 37	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 for S.A.W of high-strength, low alloyed steels
Good metal-to-metal wear resistance