

## Tubular Wire for Gas Shielded Arc Welding KJTUBG - 24

### Standards:

AWS A5.29

E 8T1 - Ni1

### Weld Metal Chemical Analysis (%):

Wire + Shielded Gas	C	Si	Mn	Ni
KJGTUBG - 24 + 100 %CO <sub>2</sub>	0.03 - 0.06	0.3 - 0.5	1.2 - 1.4	1.0 - 1.2

### Weld Metal Mechanical Properties:

Wire + Shielded Gas	U.T.S. ( Mpa)	Y.T.S. ( Mpa)	EL (%)	Charpy test	
				RT	-40°C
KJGTUBG - 24 + 100 %CO <sub>2</sub>	570 - 590	510 - 525	24 - 26	75 - 95	45 - 60

### Packing and Diameter:

In layer winding plastic spool according to below table or at buyer's option

Packing	Wire Dia (mm)
Spool (15 Kg)	1.20 – 1.60

### Description:

KJTUBG-24 is a Rutile Type Flux Cored Wire

Containing Nickel, makes it most suitable for welding steels with extensive application in shipbuilding, offshore industries, oil platform, bridges and tanks as well as the welding for steel made high strength superstructures.

High speed welding with extreme welding residue in different welding conditions and positions.

Shield Gas: Ar + 20% Co<sub>2</sub> or 100% Co<sub>2</sub>

Welding Current: DCEP

Welding positions: Flat, Horizontal, Filet, Upward, Downward, Overhead