

## Tubular Wire for Gas Shielded Arc Welding KJTUBG - 28

### Standards:

E 81T1 - K2

### Weld Metal Chemical Analysis (%):

Wire + Shielded Gas	C	Si	Mn	Ni
KJGTUBG - 28 + 100 %CO <sub>2</sub>	0.03 - 0.06	0.3 - 0.5	1.05 - 1.25	1.35 - 1.55

### Weld Metal Mechanical Properties:

Wire + Shielded Gas	U.T.S.	Y.T.S.	EL	Charpy test	
	( Mpa)	( Mpa)	(%)	RT	-40°C
KJGTUBG - 28 + 100 %CO <sub>2</sub>	565 - 575	435 - 450	24 - 26	55 - 65	35 - 50

### 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-28 is a Rutile type Flux Cored Wire

Good flexibility, crack and weld impact resistance even at -40°C due to the nickel content.

Suitable for welding heavy steel structures and shipbuilding.

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

Applicable to multi-pass welding for thick sheets of X and V joints.

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