

Submerged Arc Welding Flux KJF-232

Standard

DIN 32522
BCS4 85 1 DCEP 13B-3-16

Strip Chemical Analysis (%)

Strip	C	Si	Mn	Cr	Ni
KJStrip - 420	0.25-0.40	Max0.5	Max0.6	12.0-14.0	Max0.6

Weld Metal Chemical Analysis (%)

Flux + Strip	Thickness (mm)	%C	%Si	%Mn	%Cr	%Ni	Mo	Hardness (HRC)
KJF - 232 + KJStrip - 420	5	0.2 - 0.4	0.8 - 1.0	Max0.4	12.5 - 13.5	Max 0.5	Max 0.5	47 - 50

Technical Specifications

Basicity Index	1.0 According to Boniszewski formula
Density	1.10 Kg/dm ³
Re-drying	350 ± 25° C /2hr
Current	AC / DCEP
Packing	25 Kg bag (3 layers) / other sizes as per buyer's order

Descriptions

Calcium Silicate Agglomerated Flux
Suitable for cladding continuous casting and pinch rollers using strip electrodes (420)
Excellent detachability even in high temperature