

Submerged Arc Welding Flux KJF-512

Standards

AWS
A5.17 : F7AZ - EM12

EN 760
S A AR 1 86 AC

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	P	S
KJF - 512 + KJS - 120 (S2)	0.05 - 0.07	0.55 – 0.65	1.0 - 1.3	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Flux + Wire	U.T.S.	Y.T.S.	EL	Charpy test	
	(Mpa)	(Mpa)	(%)	RT	0°C
KJF - 512 + KJS - 120 (S2)	540 - 560	440 - 460	25 - 27	45 – 65	---

Technical Specifications

Basicity Index	0.4 According to Boniszewski formula
Density	1.25 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

Advantages

Aluminate Rutile Agglomerated flux

Good weld bead and easy slag detachability

Suitable for all sections and metal structures using different grades of S.A.W wires of sizes 1.6 to 5mm

Appropriate for welding on structural steel, normal tanks, fillet welds, and metal structure