

## Submerged Arc Welding Flux KJF-614

### Standards

AWS	EN 760
A5.17 : F7A2 - EM12	
A5.23 : F9A4 – EA2	S A AB 1 69 AC H5

### Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Mo
KJF - 614 + KJS - 120 ( S2 )	0.04 - 0.06	0.25 – 0.30	1.5 - 1.75	---
KJF - 614 + KJS - 124 ( S2Mo )	0.04 - 0.06	0.25 – 0.35	1.65 - 1.9	0.40 – 0.50

### Weld Metal Mechanical Properties

Flux + Wire	U.T.S.	Y.T.S.	EL	Charpy test			
	( Mpa)	( Mpa)	(%)	RT	-30°C	-40°C	-50°C
KJF - 614 + KJS - 120 ( S2 )	480 - 510	400 - 420	21 - 23	80-90	40-45	---	---
KJF - 614 + KJS - 124 ( S2Mo )	620 - 635	540 - 565	20 - 22	65-80	40-45	30 - 35	---

### Technical Specifications

<b>Basicity Index</b>	1.5 According to Boniszewski formula
<b>Density</b>	1.25 Kg/dm <sup>3</sup>
<b>Re-drying</b>	350 ± 25° C /2hr
<b>Current</b>	AC / DCEP
<b>Packing</b>	25 Kg bag (3 layers) / other sizes as per buyer's order

### Advantages

Basic Aluminate Agglomerated Flux

Suitable for welding thick longitudinal oil and gas pipes up to X80 grade

Outstanding properties in combination with TB content wire in four wires welding (sour gas pipe welding)

Excellent slag detachability even in high temperature with homogenous weld bead without undercut.