

## Submerged Arc Welding Flux KJF-630

### Standards

AWS	EN 760
A5.17 : F7A4 - EM12	S A AB 1 67 AC H5
A5.23 : F8A4 – EA2	

### Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Mo
KJF - 630 + KJS - 120 ( S2 )	0.04 - 0.06	0.3 – 0.35	1.4 - 1.55	---
KJF - 630 + KJS - 124 ( S2Mo )	0.04 - 0.06	0.3 – 0.35	1.5 - 1.7	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
KJF - 630 + KJS - 120 ( S2 )	490 - 510	400 - 420	25 - 27	130-140	80-90	50-40
KJF - 630 + KJS - 124 ( S2Mo )	550 - 590	470 - 490	25 - 27	85-95	35-40	30 - 33

### 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 spiral and longitudinal welding of thick oil and gas pipes up to X80 grade  
 Excellent slag detachability even in high temperature  
 Homogenous weld bead without undercut.