Submerged Arc Welding Flux
KJF-910

Standards

AWS	EN 760
A5.17 : F7A2 - EM12	S A FB 1 55 AC H5
A5.17 : F7P5 – EH14	
A5.17 : F7P5 - EM12K	

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	P	P
KJF - 910 + KJS - 120 (S2)	0.04 - 0.06	0.20– 0.30	0.8 - 1.0	Max 0.03	Max 0.03
KJF - 910 + KJS - 122 (S2Si)	0.04 - 0.06	0.25 – 0.35	0.85 - 1.10	Max 0.03	Max 0.03
KJF - 910 + KJS - 126 (S4)	0.06 - 0.08	0.20 – 0.30	1.50 - 1.60	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Flux + Wire	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test RT	-30°C	-50°C	-60°C
KJF - 910 + KJS - 120 (S2)	500 - 520	415 - 430	26 - 27	100-120	35-45	---	---
KJF - 910 + KJS - 122 (S2Si) P.W	505 - 515	415 - 435	26 - 28	110-130	55-65	30-45	---
KJF - 910 + KJS - 126 (S4)P.W	510 - 530	410 - 430	24 - 26	---	---	55-65	35-45

Technical Specifications

Basicity Index	2.5 According to Boniszewski formula
Density	1.25 Kg/dm3
Re-drying	350 ± 25° C /2hr
Current	AC / DCEP
Packing	25 Kg bag (3 layers) / other sizes as per buyer's order

Advantages

Fluoride Basic Agglomerated Flux
Suitable for welding high resistance low alloy steels (A516Gr, X70, E36, A36) Shipbuilding, offshore, heat exchangers, boilers
Having proper mechanical and metallurgical properties
Suitable multi pass joints with regular weld bead.