

Submerged Arc Welding Flux KJF-915

Standards

EN 760
S A FB 2 88AC H5

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Mo	Ni	Cr	Cu
KJF - 915 + KJTUBS - 322	0.04 - 0.06	0.5 - 0.7	0.8 - 1.0	0.45-0.55	1.8-2.1	1.1-1.3	<0.2
KJF - 915 + KJTUBS - 414	0.05 - 0.07	0.6 - 0.8	0.7 - 0.9	0.9-1.2	4.5-5.0	12.5-14.0	<0.2

Weld Metal Mechanical Properties

Flux + Wire	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test RT
KJF - 915 + KJTUBS - 322	790 - 820	650 - 670	19 - 21	100-120
KJF - 915 + KJTUBS - 414	Hardness 40 – 44 HRC /As Weld			

Technical Specifications

Basicity Index	2.45 According to Boniszewski formula
Density	1.20 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

Fluoride Basic Agglomerated Flux
 Suitable for cladding on heat resistance, ferritic & martensitic stainless steels
 The weld metal is completely neutral and content of Carbon, Silicium and Manganese
 Very low Hydrogen content in weld metal
 Easy slag detachability even in high temperatures
 Used conveniently in cladding and surfacing with flux cored wire (FIFO Method) especially in oscillation welding.