Submerged Arc Welding Flux
KJF-920

Standards

EN 760

S A FB 2 88DC H5

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Cr	Mo	W	V	Ni
KJF - 920 + KJTUBS - 320	0.07 - 0.09	0.70– 1. 0	1.8 - 2.0	1.2- 1.5	0.4-0.6	---	---	---
KJF - 920 + KJTUBS - 350	0.3 - 0.4	0.7 – 0.9	1.3 – 1.5	5.0 – 6.0	1.7-1.9	1.2 -1.4	0.15	0.2 – 0.3

Weld Metal Mechanical Properties

Flux + Wire	Hardness (HRC)
KJF - 920 + KJTUBS - 320	27 -33 HRC /As Weld
KJF - 920 + KJTUBS - 350	48 -52 HRC /As Weld

Technical Specifications

Basicity Index	2.40 According to Boniszewski formula
Density	1.30 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 surfacing and cladding especially with flux cored wire (FIFO method)
Appropriate for stringer bid welding
Ideal for train wheel rebuild and cladding, as well as welding the medium carbon high alloy superior hardness steels
Easy slag detachability even in high temperatures with smooth
Very low Hydrogen content in weld metal