

## Submerged Arc Welding Flux KJF-930

### Standards

AWS	EN 760
A5.23 : F7A4 - EA2	
A5.23 : F8A6 – EH14	S A FB 1 55 AC H5

### Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Mo
KJF - 930 + KJS - 124 ( S2Mo )	0.03 - 0.05	0.20– 0.35	0.9 - 1.1	0.45 – 0.5
KJF - 930 + KJS – 126 ( S4 )	0.03- 0.05	0.25 – 0.35	1.0 - 1.2	----

### 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 - 930 + KJS - 124 ( S2Mo )	490 - 510	410 - 430	27 - 30	170-190	35-45	50 - 55	30 - 35
KJF - 930 + KJS – 126 ( S4 )	580 - 610	470- 490	26 - 29	190-210	170-190	---	100-120

### Technical Specifications

<b>Basicity Index</b>	3.0 According to Boniszewski formula
<b>Density</b>	1.20 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

Fluoride Basic Agglomerated Flux  
 Suitable for welding steels have high impact toughness at subzero temperature  
 Easy slag detachability even in high temperatures  
 Good weld bead