Submerged Arc Welding Flux
KJF-933

Standards

EN 760

S A FB 3 C Cr 88 DC H5

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Cr
KJF - 933 + KJS - 110 (S1)	0.15	0.6 – 0.8	1.0 – 1.2	1.6 – 1.9

Weld Metal Mechanical Properties

Flux + Wire	2 layer weld metal hardness (6mm)
KJF - 933 + KJS - 110 (S1)	Hardness : 32 – 37 Cooling under blanket until 40 °C

Technical Specifications

Basicity Index	2.45 According to Boniszewski formula
Density	1.20 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 cladding and surfacing using carbon steel Flux Cored Wire
Leaving weld metal with appropriate harness without any crack
Excellent detachability even in high temperature
Smooth and homogenous weld bead
Low hydrogen content in weld metal