

Submerged Arc Welding Strip KJStrip - 420

Standards

AWS A5.9

ER420

Weld Metal Chemical Analysis (%)

	C	Si	Mn	Cr	Mo	Ni
Strip + Flux	0.25 - 0.40	Max 0.5	Max 0.6	12.0 – 14.0	Max 0.75	Max 0.6
KJStrip – 420 + KJF - 232	0.2- 0.4	0.80 - 1.0	0.3 – 0.4	12.5 – 13.5	----	0.40-0.50

Weld Metal Mechanical Properties

Strip + Flux

Hardness

KJStrip – 420 + KJF - 232

Weld metal hardness 47- 50 HRC

Wire Diameter and Packing

Packing: according to below details at customer's option

Packing	Strip Dimension (mm)
Drum (50+-5 ks)	50 * 0.5
25Kgs Coil and Drum	2.40 - 3.20 - 4.0 - 5.0

Advantages

Used with KJF-232 for cladding of abrasion resistant rollers in humid environment and surface corrosion exposed to chemical materials

Current: DCEP/AC