

Submerged Arc Welding Flux KJF-215

Standards

AWS
A5.17 : F7AZ - EM12

EN 760
S A CS 1 86 AC

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	P	S
KJF - 215 + KJS - 120 (S2)	0.04 - 0.06	0.6 – 0.8	1.05 - 1.15	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Flux + Wire	U.T.S.	Y.T.S.	EL	Charpy test	
	(Mpa)	(Mpa)	(%)	RT	0°C
KJF - 215 + KJS - 120 (S2)	490 - 520	410 - 430	25 - 29	60 - 80	30 - 45

Technical Specifications

Basicity Index	0.9 According to Boniszewski formula
Density	1.15 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

Calcium Silicate –Manganese Silicate Agglomerated Flux
 Excellent Slag Detachability
 Smooth and Shiny Weld bead
 Twin or Multi Wire Welding
 Suitable for Welding on Structural Steel, Pressure Vessels, LPG Tanks, Air Compressors