

Submerged Arc Welding Flux KJF-610

Standards

AWS	EN 760
A5.17 : F7A3 - EM12	
A5.17 : F7A3 - EM12K	
A5.17 : F7P4 - EH14	S A AB 1 69 AC H5
A5.23 : F8A4 - EA2	
A5.23 : F8AZ – ECB2	

Weld Metal Chemical Analysis (%)

Flux + Wire	C	Si	Mn	Cr	MO
KJF - 610 + KJS - 120 (S2)	0.04 - 0.06	0.25 – 0.35	1.5 - 1.7	---	---
KJF - 610 + KJS - 122 (S2Si)	0.04 - 0.06	0.35 – 0.45	1.55 - 1.80	---	---
KJF - 610 + KJS - 126 (S4)	0.05 - 0.07	0.30 – 0.40	1.80 - 2.10	---	---
KJF - 610 + KJS - 124 (S2Mo)	0.04 - 0.06	0.35 – 0.45	1.55 - 1.75	---	0.40 – 0.50
KJF - 610 + KJTUBS - 310 (S2CrMo1)	0.04 - 0.07	0.35 – 0.45	1.50 - 1.65	1.0 - 1.2	0.40 – 0.50

Weld Metal Mechanical Properties

Flux + Wire	U.T.S.	Y.T.S.	EL	Charpy test		
	(Mpa)	(Mpa)	(%)	RT	-40°C	-50°C
KJF - 610 + KJS - 120 (S2)	480 - 510	420 - 440	25 - 27	80-95	45-55	---
KJF - 610 + KJS - 122 (S2Si)	505 - 530	430 - 460	25 - 27	85-95	40-50	---
KJF - 610 + KJS - 126 (S4)P.W	525 - 540	425 - 440	24 - 26	90-100	45-55	33-38
KJF - 610 + KJS - 124 (S2Mo)	570 - 600	470 - 490	23 - 25	90-100	40 - 44	---
KJF - 610 + KJTUBS - 310 (S2CrMo1)	590 - 610	500 - 520	21 - 23	50-65	---	---

Technical Specifications

Basicity Index	1.5 According to Boniszewski formula
Density	1.20 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

- Basic Aluminate Agglomerated Flux
- Excellent slag detachability even in high temperature
- Applicable to twin and tandem welding
- Favorable impact strength (down to -40°C)
- Suitable for welding high resistant steels, shipbuilding, pressure tanks, water pipes, construction steel joints and fine grain steels
- Applicable to relatively high welding speed (up to 150cm/min)

Low hydrogen content of weld metal