

Submerged Arc Welding Wire KJS - 123

Standards

AWS A5.17

EH10K

EN 760

S3Si

Weld Metal Chemical Analysis (%)

	C	Si	Mn	P	S
Wire (S3Si)	0.06 - 0.10	0.15 – 0.25	1.33 - 1.65	Max 0.03	Max 0.03
KJS-123 (S3Si) + KJF - 610	0.04 - 0.06	0.35 - 0.45	1.65 - 1.85	Max 0.03	Max 0.03
KJS-123 (S3Si) + KJF - 910	0.04 - 0.06	0.25 - 0.35	1.2 - 1.4	Max 0.03	Max 0.03

Weld Metal Mechanical Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test		
				RT	-30 °C	-40°C
KJS-123 (S3Si) + KJF - 610	525 - 545	455 - 475	24 - 26	75- 95	45 - 60	30 - 35
KJS-123 (S3Si) + KJF – 910(P.W)	515 - 525	425 - 445	25 - 27	100 - 120	50 - 60	35 - 45

Wire Diameter and Packing

Packing: In Drum of 350 – 450Kgs, Coil of 25Kgs or Spool of 15Kgs according to below details at customer's option

Packing	Wire Dia (mm)
15Kgs Spool	1.60 - 2.40
25Kgs Coil and Drum	2.40 - 3.20 - 4.0 - 5.0

Advantages

Copper Coated Wire, Suitable for Submerged Arc Welding of Low Alloy and C-Mn Steel

Having suitable metallurgical properties with KJF-610 or KJF-910 for high-pressure tanks and offshore

Current: DCEP/AC