Data Sheet

KJF – 261

Classifications
ISO 14174 : S A CS 1 99 AC
A5.17 : F7A2 – EM12
A5.17 : F8A2 – EM12K
A5.23 : F9A2 – EA2

All Weld Metal Chemical Composition %							
Flux + Wire	**C**	**Si**	**Mn**	**Mo**	**S**	**P**	**Cu**
KJF-261 + KJS-120(S2)	**0.07**	**0.65 – 0.85**	**1.55 – 1.75**	**….**	**0.02**	**0.02**	**0.05**
KJF-261 + KJS-122(S2Si)	**0.06**	**0.75 – 0.85**	**1.6 – 1.8**	**….**	**0.02**	**0.02**	**0.05**
KJF-261 + KJS-124(S2Mo)	**0.05**	**0.8 – 0.9**	**1.6 – 1.8**	**0.4**	**0.02**	**0.02**	**0.05**

Mechanical Properties for All Weld Metal					
Flux + Wire	**U. T . S . (Mpa)**	**Y . S . (Mpa)**	**Elongation %**	**Charpy V – Notch Impact Test**	
				R.T.	**0 ° C**
KJF-261 + KJS-120(S2)	**530 – 550**	**430 – 450**	**> 26**	**80 ± 10**	**50 ± 10**
KJF-261 + KJS-122(S2Si)	**560 – 580**	**470 – 490**	**> 26**	**70 ± 10**	**50 ± 10**
KJF-261 + KJS-124(S2Mo)	**660 – 680**	**540 – 560**	**> 25**	**60 ± 10**	**50 ± 10**

Technical Specifications	
Basicity Index	**1 According to Boniszewski formula**
Density	**1.2 Kg/dm3**
Re-drying	**350 ± 25 ° C /2hr**
Current	**AC / DCEP**
Packing	**25 Kg bag (3 layers) / other sizes as per buyer's order**

Description:

KJF-261 is an agglomerated calcium silicate-type welding flux. Due to its specially developed formulation and manufacturing process, this flux is suitable for tandem and multi-wire of longitudinally welded and spiral-welded steel pipes, with base metal grades up to ST52.

Key Features and Advantages

- Suitable for welding small-diameter pipes at welding speeds of up to 180 cm/min.
- Suitable for pipe welding applications requiring impact testing at 0°C.
- Uniform weld profile, with optimal bead height and angle.
- Smooth, bright weld surface free from undercut.
- Easy slag removal without adhesion.
- Uniform and consistent grain size, with high mechanical strength and excellent resistance to breakdown and fines generation.
- Effective escape of entrapped gases and removal of impurities, thereby helping to prevent weld defects.
- Suitable for longitudinal and circumferential welding of thick-plate tanks requiring impact testing at 0°C.