Data Sheet

KJF – 261C

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-261C + KJS-120(S2)	0.07	0.65 – 0.85	1.55 – 1.75	….	0.02	0.02	0.05
KJF-261C + KJS-122(S2Si)	0.06	0.75 – 0.85	1.6 – 1.8	….	0.02	0.02	0.05
KJF-261C + 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-261C + KJS-120(S2)	530 – 550	430 – 450	> 26	80 ± 10	50 ± 10
KJF-261C + KJS-122(S2Si)	550 – 580	470 – 490	> 26	70 ± 10	50 ± 10
KJF-261C + 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-261C is an agglomerated calcium silicate-type welding flux. Due to its specially developed formulation and manufacturing process, it is an ideal choice for high-speed welding of thin-walled components, including various types of tanks, LPG cylinders, fire extinguishers, and air compressor vessels.

Key Features and Advantages

- Uniform weld profile, with optimal bead height and angle.
- Smooth, bright weld surface free from undercut.
- Rapid weld metal solidification and easy slag removal.
- Uniform and consistent grain size, high mechanical strength, and excellent resistance to breakdown and fines generation.
- Suitable for welding with wire diameters ranging from 1.2 to 2.4 mm at welding speeds of 60–120 cm/min.
- Effective escape of entrapped gases and removal of impurities, thereby helping to prevent weld defects.