Data Sheet

KJF – 611

Classifications
ISO 14174 : S A AB 1 69 AC
AWS A5.17 : F7A4 – EM12

All Weld Metal Chemical Composition %							
Flux + Wire	**C**	**Si**	**Mn**	**Mo**	**S**	**P**	**Cu**
KJF-611 + KJS-120(S2)	**0.05**	**0.3 – 0.4**	**1.75 – 1.9**	**….**	**0.01**	**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.	**- 40 ° C**
KJF-611 + KJS-120(S2)	**520 – 540**	**445 – 465**	**27 - 29**	**210 ± 10**	**110 ± 10**

Technical Specifications	
Basicity Index	**1.4 According to Boniszewski formula**
Density	**1.15 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-611 is an agglomerated alkaline aluminate-type welding flux with below features:

Key Features and Applications

- Suitable for welding a wide range of metal sections and steel structures using Submerged Arc Welding (SAW) wires with diameters ranging from 1.6 to 5.0 mm.
- Suitable for welding pressure vessels, boilers, offshore oil platforms, ships, steel structures, and superstructures requiring impact strength at temperatures as low as −40°C.