

Tubular Wire For Gas Shielded Arc Welding

KJTUBG - 24

Standards:

AWS A5.29

E 81T1 - Ni1

Weld Metal Chemical Analysis (%):

Wire + Shielded Gas	C	Si	Mn	Ni
KJTUBG - 24 + (Ar + 20 %CO ₂)	0.03 - 0.06	0.2 - 0.4	1.2 - 1.4	1.0 - 1.2

Weld Metal Mechanical Properties:

Wire + Shielded Gas	U.T.S. (Mpa)	Y.S. (Mpa)	El %	Charpy Impact ISO – V (J)	
				R.T.	-40°C
KJTUBG - 24 + (Ar + 20 %CO ₂)	570 - 590	510 - 525	24 - 26	75 - 95	45 - 60

Packing and Diameter:

In layer winding plastic spool or at buyer's option according to below table

Packing	Wire Dia(mm)
Spool (15Kg)	1.20 - 1.40 - 1.60

Descriptions:

KJTUBG-24 is a Rutile type Flux Cored Wire with nickel content applicable to steels with extensive application in ship building, metal structures and offshore industries as well as for bridges, tanks and welding of steel made medium or high strength super structures. The wire is suitable for high speed welding with extreme weld bead in different welding positions. It is approved by GL, BV and DNV classification institutes.

Shield Gas: Ar + 20% CO₂ or 20% CO₂

Welding Current: DCEP

Welding positions: Flat, Horizontal, Filet, Upward, Downward, Overhead

KJTUBG-24 is almost equivalent to the followings:

Lincoln Electric Outershield 81Ni1-H

ESAB Tubrod 15.19

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