

## Tubular Wire For Gas Shielded Arc Welding KJTUBG - 25

### Standards:

AWS A5.29

E 81T5 - B2

### Weld Metal Chemical Analysis ( % ):

Wire + Shielded Gas	C	Si	Mn	Cr	Mo
KJTUBG - 25 + (Ar + 20 %CO <sub>2</sub> )	0.04 - 0.06	0.4 - 0.6	0.9 - 1.1	1.1 - 1.3	0.42 - 0.55

### Weld Metal Mechanical Properties:

Wire + Shielded Gas	U.T.S. (Mpa)	Y.S. (Mpa)	El %	Charpy Impact ISO - V (J)
				R.T.
KJTUBG - 25 + (Ar + 20 %CO <sub>2</sub> )	640 - 660	545 - 565	23 - 25	35 - 45

❖ نمونه بمدت یک ساعت در دمای 610 °C تنش زدایی شده است

### 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-25 is a fully basic, low-hydrogen Flux Cored Wire suitable for creep resistant steels, build and re-build of different sections in heavy industries and welding of high strength steels.

Shield Gas: Ar + 20% Co<sub>2</sub> or 100% Co<sub>2</sub>

Welding Current: DCEN

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

KJTUBG-25 is almost equivalent to the followings:

Lincoln Electric Outershield 81B2-H

ESAB Tubrod 15.20