

## Seamless Copper Coated Tubular Wire For Gas Shielded Arc Welding

### KJTUBG - 28S

<b>Standards:</b>
AWS A5.29
E 81T1 - K2H4

<b>Weld Metal Chemical Analysis ( % ):</b>				
Wire + Shielded Gas	C	Si	Mn	Ni
KJTUBG - 28S + 100 %CO <sub>2</sub>	0.05 - 0.07	0.30 - 0.40	1.0 - 1.1	1.45 - 1.55

<b>Weld Metal Mechanical Properties:</b>					
Wire + Shielded Gas	U.T.S. (Mpa)	Y.S. (Mpa)	El %	Charpy Impact ISO – V (J)	
				R.T.	-60°C
KJTUBG - 28S + 100 %CO <sub>2</sub>	555 – 575	425 - 440	23 - 25	50 - 65	30 - 45

### 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-28S is a Rutile seamless Flux Cored Wire with nickel content homonymous to the seamed type causing remarkable flexibility and crack resistance even in -40°C. Suitable for heavy metal structures, shipbuilding and offshore industries. The wire is suitable for high speed welding with extreme weld bead in different welding positions. It is copper coated and seamless which creates a constant arc and stable weld increasing humidity resistance and preserves surface oxidation in humid areas if compared to KJTUBG-28 It is approved by GL, BV and DNV classification institutes.

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

Welding Current: DCEP

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

KJTUBG-28S is almost equivalent to the followings:

Lincoln Electric Outershield 91K2 – H

FILEUR ARS 12 C