

Tubular Wire For Submerged arc welding KJTUBS - 310

Standard

DIN 8555

UP 1 - GF - 200 - T

Typical weld metal chemical composition (weight %)

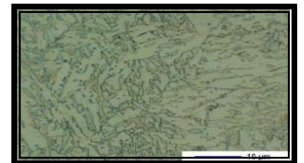
Wire + Flux	C	Si	Mn	Cr	Mo
KJTUBS - 310 + KJF - 610	0.04 - 0.07	0.35 - 0.45	1.50 - 1.65	1.0 - 1.2	0.4 - 0.5
KJTUBS - 310 + KJF - 910	0.06 - 0.08	0.2 - 0.3	0.8 - 1.0	1.05 - 1.25	0.45 - 0.55
KJTUBS - 310 + KJF - 915	0.07 - 0.09	0.55 - 0.75	1.2 - 1.4	1.1 - 1.3	0.45 - 0.6

Typical Weld Metal Properties

Wire + Flux	U.T.S. (Mpa)	Y.T.S. (Mpa)	EL (%)	Charpy test R.T.
KJTUBS - 310 + KJF - 610	590 - 610	500 - 520	21 - 23	50 - 65
KJTUBS - 310 + KJF - 910	580 - 600	490 - 520	21 - 23	65 - 75
KJTUBS - 310 + KJF - 915	630 - 650	560 - 570	20 - 22	55 - 70

Metallurgical Weld Metal Properties

Machinability	Good		
Polarity / Current Type	DCEP		
Microstructure	Ferrite		
Impact resistance	Good associated high-strength		
Wire + Flux	KJTUBS - 310 + KJF - 610	KJTUBS - 310 + KJF - 910	KJTUBS - 310 + KJF - 915
Weld metal hardness (HB)	210 - 225	205 - 220	215 - 230



Packing

250Kgs drum or 25 Kgs coil, depending on wire size and customer's order

Welding method

FIFO Technology

Wire Dia. (mm)

1.60,2.0,2.4,2.80,3.20

Description

Tubular wire for hardfacing of Cr – Mo type creep resistant steels using S.A.W method
Suitable for welding thin sheets and corner joints with high-strength
Good choice for rebuilding (1% Cr. 0.5% Mo) alloy or slightly alloyed steels.