

## Tubular Wire For Submerged arc welding KJTUBS - 340

### Standard

**DIN 8555**

UP 1 - GF - 350 - G

### Typical weld metal chemical composition (weight %)

Wire + Flux	C	Si	Mn	Cr	Mo	Nb
<b>KJTUBS - 340 + KJF - 915</b>	0.11 - 0.13	0.4 - 0.6	1.3 - 1.5	4.1 - 4.3	0.45 - 0.65	0.14 - 0.16

### Metallurgical Weld Metal Properties

<b>Machinability</b>	Good
<b>Polarity / Current Type</b>	DCEP
<b>Microstructure</b>	martensitic - Bainite
<b>Metal-to-Metal wear resistance</b>	Good
<b>Impact resistance</b>	Moderate
<b>Wire + Flux</b>	KJTUBS - 340 + KJF - 915
<b>Weld metal hardness (HB)</b>	325 - 375



### Packing

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

Welding method	FIFO Technology
Wire Dia. (mm)	2.4,2.80,3.20

### Description

Tubular wire for SAW hardfacing

Suitable for rebuilding and surfacing of axes and similar parts exposed to metal-to-metal wear, such as rollers and bulldozer wheels and road construction machines.