Submerged Arc Welding Flux
KJF-231

Standards

DIN 32522

B CS 4 85 1 Ni Mo DCEP

Strip Chemical Analysis (%)

Strip	C	Si	Mn	Cr	Mo	Ni
KJStrip - 430	Max 0.10	Max 0.50	Max 0.60	15.5-17.0	Max0.75	Max 0.60

Weld Metal Chemical Analysis (%)

Flux + Strip	Thickness (mm)	%C	%Si	%Mn	%Cr	%Mo	%Ni	Hardness (HRC)
KJF - 231 + KJStrip - 430	5	0.05 - 0.07	0.7- 0.9	0.3 - 0.5	12 - 14	0.8 - 1.2	4 - 5	43 - 48

Technical Specifications

Basicity Index	1.0 According to Boniszewski formula
Density	1.10 Kg/dm3
Re-drying	350 ± 25° C /2hr
Current	AC / DCEP
Packing	25 Kg bag (3 layers) / other sizes as per buyer's order

Descriptions

Calcium Silicate Alloy (Mo & Ni) Agglomerated Flux
Suitable for cladding and hardfacing continuous casting rollers using strip electrodes (430,420)
Leaving weld metal with 1% Mo and 4% Ni
Excellent detachability even in high temperature