

KF-990/KW-3

Classification

AWS	A 5.17	F7A2-EM12K/ F7P2-EM12K
JIS	Z3183	S502-H
EN	14171-A	S42 3 AB S2Si
GB	T5293	F5A3-H08MnA

Basicity : 1.2

Applications and Features

- (1) General purpose flux designed to weld butt joints and both single and multiple pass fillets.
- (2) Good mechanical properties, deep penetration, good bead appearance, good slag removal and excellent X-ray quality welds.
- (3) Suitable for welding carbon steel and 490N/mm² grade steel in ship-building, steel structures, bridges and pipes.

Welding Position



Welding Instruction

Please refer to Appendix E.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.38	1.61	0.015	0.010

Typical Mechanical Properties of Weld Metal

Heat treatment condition	Tensile N/mm ²	Yield Strength N/mm ²	Elongation %	Charpy V-Notch	
				°C	J
As-welded	580	500	29	0	70
				-29	58
PWHT	497	405	36	0	68
				-29	50

Size and Suggested Operating Range (AC/DC+)

Diameter (mm)		3.2	4.0	4.8	5.6
Current (A)	F/H-fillet	300~450	400~600	500~700	600~1000