

SAW Consumables for High Tensile Strength Steel

KF-880/KW-1

Classification

AWS	A 5.17/A5.17M	F7A4-EH14
JIS	Z3183	S502-H
EN	14171-A	S 50 4 FB S4
GB	T5293	F5A4-H10Mn2

Basicity : 2.3

Applications and Features

- (1) Good mechanical properties, deep penetration, good bead appearance, good slag removal and excellent X-ray quality welds.
- (2) Excellent toughness at low temperature due to its high basicity.
- (3) Suitable for welding carbon steel and 490N/mm² grade steel in ship-building, pressure vessel and offshore structure.

Welding Position



Welding Instruction

Please refer to Appendix E.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.09	0.47	1.62	0.018	0.004

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
598	516	31	-29	110
			-40	86

Size and Suggested Operating Range (AC/DC+)

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