

## SAW Consumables for High Tensile Strength Steel

# KF-550/KW-3

### Classification

AWS	A 5.17/A5.17M	F7A2-EM12K
JIS	Z3183	S502-H
EN	14171-A	S42 3 AB S2Si
GB	T5293	F5A2-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/mm<sup>2</sup> 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
0.05	0.42	1.51	0.018	0.007

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
522	426	32	-18	91
			-29	74

### Size and Suggested Operating Range (AC/DC+)

Diameter (mm)	2.0	2.4	3.2	4.0	4.8	5.6
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Current (A)	F/H-fillet	250~350	300~400	350~450	400~600	500~700	600~1000
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