

Flux Cored Wire for Low Temperature Alloy

KFX-111K3

Classification		
AWS A5.29/A5.29M	E111T1-K3C/E761T1-K3C	
JIS Z3313	T764T1-1CA-N3M2	
EN ISO 18726-A	T69 4 Mn2NiMo P C1 1 H5	
GB T17493	E761T1-K3C	

Shielding Gas: 100% CO₂

Applications and Features

- (1) KFX-111K3 is suitable for welding 760N/mm² grade steel.
- (2) Excellent toughness at low temperature due to 2%Ni-0.4%Mo.
- (3) Ideal for welding pressure vessel, steel structure, offshore structure, tank, and pipeline.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.27	1.55	0.016	0.006	2.47	0.39

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
771	736	19	-20	94
			-40	61

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6
F/HF	140~300A/23~36V	150~350A/22~34V	200~450A/28~42V
H	140~280A/22~33V	150~280A/22~32V	220~280A/23~29V
V-up/OH	140~220A/22~28V	150~230A/22~28V	160~280A/22~28V
V-down	230~280A/28~33V	250~300A/28~32V	250~320A/28~32V