

KF-880

KW-12KH

Classification

AWS A 5.17/A5.17M F7A8-EH12K/F48A6-EH12K

JIS Z3183

S502-H

EN ISO 14171-A

S 46 6 FB S3Si

Basicity : 3.1

GB T5293

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Applications and Features

- (1) Suitable for welding 490N/mm² grade steel.
- (2) KF-880 is fluoride-basic agglomerated flux providing low hydrogen weld metal, good bead appearance and slag removal.
- (3) The combination of KF-880 and KW-12KH provides the excellent toughness at -60°C.
- (4) Ideal for welding shipbuilding, offshore structure and foundation of offshore wind mill.

Welding Position



Welding Instruction

Please refer to Appendix E.

Typical Chemical Composition of Weld Metal (wt%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.08 | 0.35 | 1.43 | 0.015 | 0.002 |

Typical Mechanical Properties of Weld Metal

| Tensile Strength | Yield Strength | Elongation | Charpy V-Notch | |
|-------------------|-------------------|------------|----------------|-----|
| N/mm ² | N/mm ² | % | °C | J |
| 569 | 487 | 29 | -40 | 141 |
| | | | -60 | 105 |