

## Flux Cored Wire for Low Temperature Alloy

# KFX-91TK2

### Classification

AWS A5.29/A5.29M	E91T1-K2C/E621T1-K2C
JIS Z3313	T624T1-1CA-N3
EN ISO 17632-A	T55 4 Mn1.5Ni P C1 1 H5
GB T17493	E621T1-K2C

Shielding Gas: 100% CO<sub>2</sub>

### Applications and Features

- (1) KFX-91TK2 is suitable for welding 620N/mm<sup>2</sup> grade steel.
- (2) Ideal for welding high strength steel, such as HY-80, HSLA-80 and ASTM A710.
- (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
0.04	0.40	1.38	0.017	0.008	1.51

### 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
675	603	24	-20	160

### 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