

SAW Consumables for High Tensile Strength Steel

KF-330

KW-2

Classification

AWS A 5.17/A5.17M F6AZ-EL-8/F43AZ-EL-8
JIS Z3183 S421-S
EN ISO 14171-A S42 Z GS S1
GB T5293 -

Basicity : 0.8

Applications and Features

- (1) KF-330+KW-2 is suitable for welding 430N/mm² grade steel.
- (2) KF-330 is an agglomerated aluminate-titania type flux, providing smooth bead appearance, excellent slag detachability, and high-speed welding characteristics.
- (3) Ideal for thin plate and high speed welding applications such as boilers, pressure vessels, and gas cylinders.

Welding Position



Welding Instruction

Please refer to Appendix E.

Typical Chemical Composition of Weld Metal (wt%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.06 | 0.36 | 0.55 | 0.013 | 0.009 |

Typical Mechanical Properties of Weld Metal

| Tensile Strength | Yield Strength | Elongation | Charpy V-Notch | |
|-------------------|-------------------|------------|----------------|----|
| N/mm ² | N/mm ² | % | °C | J |
| 460 | 355 | 28 | 0 | 50 |