

SAW Consumables for High Tensile Strength Steel

KF-330

KW-3

Classification

AWS A 5.17/A5.17M F7AZ-EM12K/F49AZ-EM12K
JIS Z3183 S501-H
EN ISO 14171-A S42 0 AR S1
GB T5293 F5A0-H08A

Basicity : 0.8

Applications and Features

- (1) KF-330+KW-3 is suitable for welding 490N/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	0.45	0.88	0.020	0.004

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
546	455	25	0	50