

SAW Consumables for High Tensile Strength Steel

KF-550 KW-3

Classification

AWS A 5.17/A5.17M F7A2-EM12K/F49A3-EM12K
JIS Z3183 S502-H
EN ISO 14171-A S42 3 AB S2Si
GB T5293 F5A3-H08MnA

Basicity : 1.2

Applications and Features

- (1) KF-550+KW-3 is suitable for welding 490N/mm² grade steel.
- (2) KF-550 is an agglomerated aluminate-basic type flux, providing good bead appearance, high current resistance, and excellent slag detachability.
- (3) Ideal for single- or multi-electrode welding of thick plates in steel structures, pressure vessels, shipbuilding, and bridges.

Welding Position



Welding Instruction

Please refer to Appendix E.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.05	0.42	1.51	0.018	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
522	426	32	-30	54