

## SAW Consumables for High Tensile Strength Steel

# KF-660

# KW-9

### Classification

AWS A 5.17/A5.17M F8A4-EG-G/F55A4-EG-G  
JIS Z3183 S584-H  
EN ISO 14171-A S 46 3 AB SZ  
GB T5293 -

Basicity : 1.4

### Applications and Features

- (1) KF-660+KW-9 is suitable for welding 550N/mm<sup>2</sup> grade steel.
- (2) KF-660 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	Mo
0.09	0.48	1.54	0.021	0.007	0.50

### 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
624	550	28	-30	82
			-40	61