

## SAW Consumables for High Tensile Strength Steel

# KF-880 KW-1

### Classification

AWS A 5.17/A5.17M F7A4-EH14/F49A4-EH14  
JIS Z3183 S502-H  
EN ISO 14171-A S42 4 FB S4  
GB T5293 F5A4-H10Mn2

Basicity : 3.1

### Applications and Features

- ( 1 ) KF-880+KW-1 is suitable for welding 490N/mm<sup>2</sup> grade steel.
- ( 2 ) KF-880 is an agglomerated fluoride-basic type flux, providing excellent low-temperature impact toughness, good bead appearance, and excellent slag detachability.
- ( 3 ) When used with EH-14 welding wire, excellent low-temperature impact toughness at -40 °C can be obtained.
- ( 4 ) Ideal for welding applications such as pressure vessels, shipbuilding, and offshore structures.

### Welding Position



### Welding Instruction

Please refer to Appendix E.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.09	0.47	1.62	0.018	0.004

### 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
598	516	31	-40	86