

SAW Consumables for High Tensile Strength Steel

KF-880 KW-12KH

Classification

AWS A 5.17/A5.17M F7A8-EH12K/F49A6-EH12K
JIS Z3183 S502-H
EN ISO 14171-A S 46 6 FB S3Si
GB T5293 -

Basicity : 3.1

Applications and Features

- (1) KF-880+KW-12KH is suitable for welding 490N/mm² 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-12KH welding wire, excellent low-temperature impact toughness at -40 °C can be obtained.
- (4) Ideal for welding applications such as shipbuilding, offshore structures, and offshore wind power underwater foundations.

Welding Position



Welding Instruction

Please refer to Appendix E.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.35	1.43	0.015	0.002

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
569	487	29	-40	141
			-60	105