

KSF-7K6-O

For Low Temperature use
Self-Shielded Flux Cored Wire

Classifications:

AWS A5.29 E71T8-K6-J H8
A5.29M E491T8-K6-J H8
EN ISO 17632-A : T 42 4 1Ni Y N 1 H10
EN ISO 17632-B : T494T8-1NA-N1 UH10

Usage:

Suitable for offshore drilling rig, shipgilding, construction and pipe welding.

Features:

1. Basic type slag, self-shielded flux cored wire with tensile strength more than 490MPa.
2. Stable arc, little spatter, good bead appearance, easy slag removal and good weldability.
3. Good impact toughness at low temperature.

Type of Current: DCEN (DC-)

Welding Position:


Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Al
AWS	0.15	0.5-1.50	0.80	0.20	0.4-1.0	0.15	0.030	0.030	1.8
Typical	0.035	1.09	0.10	0.02	0.92	0.01	0.010	0.002	1.05

Note : Single values shown are maximum in AWS spec.

Mechanical Properties and Diffusible Hydrogen Content:

Mechanical Property	YS(Mpa)	TS(Mpa)	EL%	CVN J/°C	Heat Treatment °C x h	Diffusible Hydrogen ml/100g
AWS	400	490-620	20	27/-40	--	8
Typical	415	525	26.5	125/-40	As-Welded	7.1

Recommended Welding Parameter:

Dia./mm	Welding Position	Stick-out (mm)	Wire Feed Speed(in/min)	Current(A)	Voltage(V)
2.0	Flat	15-20	80-170	210-360	21-26
	Horizontal	15-20	90-110	240-270	23-24
	Vertical Up	15-20	60-90	180-250	20-23
	Overhead	15-20	65	170	23

Notes on Usage:

1. Be sure to remove the moisture, rust and oil on the base metal before welding.
2. Preheat and interpass temperature : 150±15°C.
3. When using the cable which is longer than 15m, the arc voltage should be raised by 1-2 voltages.
4. Do not put the wire outdoors overnight to avoid moisture.