

Submerged Arc Solid Wire / Flux

KF-810

KW-420

Classification

AWS	—	—
JIS	—	—
EN	14700	—
GB	—	—

Applications and Features

- (1) KW-420 is a submerged arc solid wire that matches with KF-810 neutral flux to produce the weld metal of AISI 420 martensitic stainless steel.
- (2) It offers good slag removal and excellent crack resistance.
- (3) It is suitable for the reclamation of continuous casting rolls, blast furnace dome, print rolls and gudgeons.

Welding Instruction

- (1) Please preheat at 200~250°C when the carbon content of the carbon steel work piece is over 0.8 wt% or the low alloy steel work piece is over 0.35wt%.
- (2) The preheat and interpass temperatures should be controlled between 200-250°C for massive work pieces and high curvature surfaces to prevent weld cracking caused by high stress.

Typical Chemical Composition of Weld Metal (wt %)

C	Si	Mn	Cr
0.150	0.33	1.20	13.10

Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer	4th layer
Hardness (HRC)	43	46	47	48

Size and Suggested Operating Range (DC+)

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
3.2	28~32	350~450	25~30