

# KF-880/ KW-80SNi1

## Classification

AWS	A 5.23/A 5.23M	F8A8-ENi1K-Ni1 /F55A6-ENi1K-Ni1
JIS	Z3352/Z3351	S A FB 2DC H5 /YS-N1
EN	14171-A	S 46 6 FB SZ2Ni1
GB	12470	F5561-H10MnSiNiA

Basicity : 2.3

## Applications and Features

- (1) KF 880 is fluoride basic agglomerated flux providing a low hydrogen weld metal.
- (2) Good mechanical properties, deep penetration, good bead appearance and good slag removal.
- (3) Excellent toughness at -60°C due to high basicity flux and Ni content.
- (4) Ideal for welding carbon steel and 550N/mm<sup>2</sup> grade steel in ship-building, pressure vessel and offshore structure with single pass or multi-pass welding.

## Welding Position



## Welding Instruction

Please refer to Appendix E.

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

C	Si	Mn	P	S	Ni
0.08	0.72	1.02	0.021	0.006	0.76

## 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
587	508	29	-40	145
			-60	105

## Size and Suggested Operating Range (AC/DC+)

Diameter (mm)		2.5	3.2	4.0	4.8
Current (A)	F/H-fillet	250~350	300~450	400~600	500~700