



SUB ARC FLUX : KFL - 222 Fluoride -Basic Type

Standard Designation

ISO 14174 – S A FB 1 67 AC H5*)
(EN 760 – SA FB 1 67 AC H5)

Application

EXCELLENT MULTY WELDABILITY FOR THICK STEEL PLATES

Designed for welding wind tower, low alloy structural steels, pipe steels, boiler steels, pressure vessel steel & fine grain steels

Flux is suitable for single and Multilayer welding of longitudinal, circumferential, and fillet welds.

Excellent slag removal in narrow groove welds of thick wall section.

Excellent current carrying capacity of more than 1500A on the lead wire in multi-wire welding processes.

Even at very high currents the welding process remains stable. The welding seam shows very good wetting, a regular flow and a very broad flat profile.

Product Information

Basicity Index 2.4

Hydrogen Diffusion % : 3.8

Polarity: AC or DCEP

Redrying

Before welding, if moisture contamination is suspected from either improper storage condition or due to atmosphere exposure, the flux should be redried at 300 to 350°C for 2 hours.

All weld metal classification of Wire Flux combination

Wire electrode	AWS A5.17/.2	Test assembly ISO 15792-1: type 1.3		AWS A5.17M/5.23M	AWS A5.17/5.23
KSW-12KM	EM12K	ISO 14171-A	S 42 4 FB S2Si	F48A4/P4- EM12K	F7A4/P4-EM12K
KSW-12KHM	EH12K	ISO 14171-A	S 42 6 FB S3Si	F48A8/F49P6-EH12K	F7A8/F7P6-EH12K
KSW-A2	EA2	ISO 14171-A	S 46 3 FB S2Mo	F55A4-EA2-A2	F8A4-EA2-A2
KSW-14KHM	EH14	ISO 14171 -S4	S AFB 1 /14171 S4	F8A8-EH14	F8A8-EH14

Chemical composition of All weld metal

Wire electrode	AWS A5.17/.2	C	Si	Mn	Mo	Ni	Cr			
KSW-12KM	EM12K	0.07	0.28	1.08						
KSW-12KHM	EH12K	0.07	0.38	1.71						
KSW-A2	EA2	0.08	0.25	1.13	0.48					
KSW-14KHM	EH14	0.07	0.25	1.68						

Mechanical Properties of All weld metal

Wire electrode	AWS A5.17/.2	Heat treatment	YS Mpa	UTS Mpa	Elong %	Kerbschlagarbeit ISO-V (J) bei				
						± 0 °C +32 °F	-20°C -4°F	-30°C -22°F	-40°C -40°F	-62°C
KSW-12KM	EM12K	AWS	440	510	30				105	
KSW-12KHM	EH12K	AWS *	490	580	29					101
KSW-A2	EA2	AWS *	550	652	26				82	
KSW-14KHM	EH14	AWS	510	550	29					95

Post Weld Heat Treatment: * 620 °C / 1 h