

	KSW-14KHM (MODI-ECOWELD)	CLASSIFICATIONS: AWS/SFA5.17: EH14 EN 1S0 14171-A-S4	 QCS-2024-CPR-0890
	Copper Coated solid Wire for Submerged Arc Welding		

Description:

KSW-14KHM is a copper coated, High-Manganese alloyed semi-killed solid wire to be used with suitable flux for submerged arc welding medium and high strength steels. It has excellent welding performance, stable arc, smooth weld pass, easy slag peeling. It could meet the requirement of high energy input multi-layer welding, multi-pass welding, double sided-single pass welding, high speed welding etc.

Applications :

- ❖ Widely used for medium & high tensile structural steels.
- ❖ Shipbuilding industry
- ❖ Non alloy structural steels
- ❖ Pipe steels
- ❖ Boiler steels

Chemical Composition of Solid Wire (WT. %):

C	Mn	Si	S	P	Cu
0.10 - 0.20	1.70 – 2.20	0.10 Max.	0.030 Max	0.030 Max	0.35 Max

Mechanical Properties of Weld Metal with SAW flux:

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation, L = 4d (%)	Charpy Impact Value (Joules)
620	520	26	80 Joules Min at -30°C

Current Conditions: DC (+)

WELDING PARAMETERS

Wire Size (mm)	1.60	2.00	2.4 / 2.5	3.15 / 3.20	4.00	5.00
Current (Amps)	250 - 350	300 - 400	350 - 450	425 - 525	475 - 575	550 - 650
Voltage (V)	26 - 29	26 - 29	27 - 30	27 - 30	27 - 30	27 - 30
Typical Travel Speed range *	5-100 IPM	5-100 IPM	5-100 IPM	5-100 IPM	5-100 IPM	5-100 IPM
Electrode Extension	13 - 19	13 - 19	19 - 32	25 - 38	25 - 38	25 - 38

Recommendation: Pay attention to welding voltage, Excessive welding voltage cause deterioration of joint properties.

* The travel speed of a welding arc can vary depending on the thickness of the plates and the type of joint being welded.

Packing :

- 25 KGS MAX. IN BASKET SPOOL & in metallic ring.
- Identification-Brand name & size is printed on label.
- Packed in a corrugated cardboard box
- 100 KGS/250 KGS/500 KGS IN DRUM PACKING

Caution: Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer to American National Standard Z49.1 "Safety in welding and cutting".

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