



廣泰金屬工業股份有限公司

KUANG TAI METAL IND. CO., LTD.

AWS A5.17 F7A4-EM12K

- Characteristics and Applications :

KF-550 (neutral type) / KW-3 is for butt or fillet submerged arc welding. It can provide less flux consumption, excellent porosity resistibility & good slag remove. High welding efficiency, good toughness can be obtained. It is suitable for multi-layer welding due to wide range of applicable welding condition.

- Notes on usages :

Dry the flux at 250 ~ 350°C for 60 minutes.

- Welding Procedure Specification :

1.	母材規範	Material specification	ASTM A572GR50
2.	銲接材料	Brand name	KF-550 / KW-3
3.	銲接方法	Welding process	SAW
4.	手動或機械	Manual or machine	MACHINE
5.	銲接姿勢	Position of welding	1F
6.	熔填金屬規範	Filler metal specification	AWS SFA-5.17
7.	熔填金屬等級	Filler metal classification	EM12K
8.	銲藥	Flux	KF-550
9.	遮護氣體	Shielding	*
10.	單道或多道	Single or multiple pass	MULTIPLE PASS
11.	單或多電極	Single or multiple arc	SINGLE ARC
12.	銲接電流	Welding current	DC
13.	極性	Polarity	DCSP OR DCRP
14.	銲接進行方式	Welding progression	STRING
15.	預熱及層間溫度	Preheat and interpass temperature	150°C
16.	後熱處理	Postheat treatment	*

銲道數 Pass No	銲線規格 Electrode Size	銲接電流 Welding Current	運行速度 Travel Speed	開槽型狀 Joint Detail
1 ~ 12	4.8 mm	550 A 28 V	6.8 mm/sec.±0.4	



廣泰金屬工業股份有限公司
KUANG TAI METAL IND. CO., LTD.

● **Typical chemical composition of weld metal (wt%)**

C	Mn	Si	P	S
0.08	1.44	0.29	0.01	0.01

● **Typical mechanical properties of weld metal**

YP N/mm2	TS N/mm2	EL %	IV J
440	520	32	At -29°C 60 - 98