

EF-100S×KD-42

For mild steel and 490MPa steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA AB 1 77 AC

• Flux/ Wire-combination

EN ISO 14171 - 2010 : S 46 2 AB S2Si

AWS A5.17 - 2015 : F7A(P)2-EM12K

KS B ISO 14171 : S 46 2 AB S2Si

JIS Z 3183 : S502-H

• SAW solid wire

EN ISO 14171 - 2010 : S2Si

AWS A5.17 - 2015 : EM12K

Description

- Active flux for limited pass welding of ship buildings, steel frames, structures and bridges.
- Bead appearance and slag removal are excellent under higher welding speed with low current.
- Good resistance to porosity on rust and primer
- High speed on dirty plate
- Applicable to both AC and DC(+)
- Redry the flux at 250~350°C for 60 minutes before use.
- Add new flux periodically when continuously reusing the flux.
- Excessive flux height may bring out poor bead appearance.

Typical chemical composition of all-weld metal (%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.05 | 0.55 | 1.60 | 0.025 | 0.012 |

Typical mechanical properties of all-weld metal

| | Y.S. | T.S. | EI. | IV (J) | | Remarks |
|--------------|----------|---------|---------|--------|-------|---------|
| | (MPa) | (MPa) | (%) | -20°C | -29°C | |
| AWS A5.17 | min. 400 | 480~660 | min. 22 | ≥ 47 | ≥ 27 | |
| EN ISO 14171 | min. 460 | 530~680 | min. 20 | ≥ 47 | ≥ 27 | |
| Example | 545 | 600 | 29 | 70 | 50 | AW |

* AW : As-Welded

Approvals

| ABS | BV | DNV |
|------|-------|-------|
| 2YTM | A2YTM | IIYTM |