

EF-200K×KD-42

For mild steel and 490MPa steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA CS 1 57 AC

• Flux/ Wire-combination

EN ISO 14171 - 2010 : S 46 5 CS S2Si

AWS A5.17 - 2015 : F7A(P)6-EM12K

KS B ISO 14171 : S 46 5 CS S2Si

JIS Z 3183 : S502-H

• SAW solid wire

EN ISO 14171 - 2010 : S2Si

AWS A5.17 - 2015 : EM12K

Description

- Single and multi-layer welding of ship buildings, structural steels, offshore structures and pressure vessels.
- Excellent impact toughness and crack resistibility.
- Good resistance to porosity on rust, scales, oil and primer.
- 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
0.08	0.35	1.65	0.026	0.009

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-50°C	-51°C	
AWS A5.17	min. 400	480~660	min. 22	≥ 27		
EN ISO 14171	min. 460	530~680	min. 20	≥ 47		
Example	550	610	29	80	80	AW

* AW : As-Welded

Approvals

ABS	BV	DNV	LR	KR	NK
3YTM	A3YTM	IIIYTM	3YTM	3YTM	KAW53TM