

EF-200V $\times$ KD-42

For mild steel and 490MPa steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA CS 1 53 AC

• Flux/Wire-combination

EN ISO 14171 - 2010 : S 42 5 CS S2Si

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

KS B ISO 14171 : S 42 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 machinery, pressure vessels, ship buildings and structural steels.
- Neutral flux for multi-pass welding.
- Excellent impact toughness at low temperature.
- Bead appearance and slag removal are excellent.
- Applicable to both AC and DC(+)
- Redry the flux at 250~350°C for 60 minutes before use.
- Excessive flux height may bring out poor bead appearance.

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S
0.08	0.29	1.20	0.026	0.008

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. 420	500~640	min. 20	≥ 47		
Example	460	530	31	80	80	AW

* AW : As-Welded