EF-100SB×KD-50

For mild steel and 490MPa steel

Classifications

- **Sub-arc flux**
  EN ISO 14174-2012 : SA AB 1 66 AC
- **Flux/Wire-combination**
  EN ISO 14171-2010 : S 46 3 AB S4
  AWS A5.17-97(R2007) : F7A2-EH14
  KS B ISO 14171-2014 : S 46 3 AB S4
  JIS Z 3183-2012 : S502-H
- **SAW solid wire**
  EN ISO 14171-2010 : S4
  AWS A5.17-97(R2007) : EH14

Description

- Single and multi-layer welding of ship buildings, bridges, structural steels and other fabrications.
- Excellent impact tougheness and crack resistibility.
- Outstanding welding characteristics and bead profile.
- Applicable to both AC and DC(+)
- Redry the flux at 250~350℃ 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	0.23	1.70	0.014	0.018

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) -29℃	IV (J) -30℃	Remarks
AWS A5.17	min. 400	480~660	min. 22	≥ 27		
EN ISO 14171	min. 460	530~680	min. 20		≥ 47	
Example	568	608	29	100	100	AW

* AW : As-Welded