

# EF-100xKD-EH12K

For mild steel and 490MPa steel

## Classifications

### • Sub-arc flux

EN ISO 14174 - 2012 : SA RS 1 81 AC

### • Flux/ Wire-combination

EN ISO 14171 - 2010 : S 46 Z RS S3Si

AWS A5.17 - 2015 : F7A(P)Z-EH12K

KS B ISO 14171 : S 46 Z RS S3Si

JIS Z 3183 : S501-H

### • SAW solid wire

EN ISO 14171 - 2010 : S3Si

AWS A5.17 - 2015 : EH12K

## Description

- Single and multi-layer welding of structural steels, pipes and general fabrications.
- Bead appearance and slag removal are excellent under higher welding speed with low current.
- Good resistance to porosity on rust 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
0.06	0.75	1.10	0.022	0.010

## Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				+20°C	0°C	
AWS A5.17	min. 400	480~660	min. 22			
EN ISO 14171	min. 460	530~680	min. 20			
Example	550	610	27	80	50	AW

\* AW : As-Welded