

EF-100HHxKD-50

For 520MPa/540MPa high tensile strength steel

Classifications

- **Sub-arc flux**
EN ISO 14174 - 2012 : SA AB 1 72 AC
- **Flux/ Wire-combination**
EN ISO 14171 - 2010 : S 46 3 AB S4
AWS A5.17 - 2015 : F8A2-EH14-G
KS B ISO 14171 : S 46 3 AB SA
JIS Z 3183 : S584-H
- **SAW solid wire**
EN ISO 14171 - 2010 : S4
AWS A5.17 - 2015 : EH14

Description

- Single and multi-layer welding of 520MPa/540MPa high tensile strength steels for structural steels, pipes, H-beams, and general fabrications.
- Excellent impact toughness and crack resistibility.
- Outstanding welding characteristics and bead profile.
- 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
0.09	0.31	1.42	0.023	0.008

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-29°C	-30°C	
AWS A5.17	min. 470	550~700	min. 20	≥ 27		
EN ISO 14171	min. 460	530~680	min. 20	≥ 47		
Example	570	620	26	90	90	AW

* AW : As-Welded