

# EF-200VxKD-Ni1K

For 560MPa high tensile strength steel

## Classifications

### • Sub-arc flux

EN ISO 14174-2012 : SA CS 1 53 AC

### • Flux/Wire-combination

EN ISO 14171-2010 : S 50 4 CS SZ

AWS A5.23-2011 : F8A(P)4-ENi1K-Ni1

KS B ISO 14171-2014 : S 50 4 CS SZ

### • SAW solid wire

EN ISO 14171-2010 : SZ

AWS A5.23-2011 : ENi1K

## Description

- Single and multi-layer welding of machinery, pressure vessels, pipes, ship buildings and structural steels
- 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	Ni
0.08	0.60	1.33	0.014	0.003	0.78

## Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-40°C	
AWS A5.23	min. 470	550~700	min. 20		≥ 27	
EN ISO 14171	min. 500	560~720	min. 18	≥ 47		
Example	590	680	24	83	83	PWHT*

\* PWHT : Post Weld Heat Treatment (620°Cx1Hr.)