

# EF-100SB×KD-B2/KD-B3

For heat resistant steel

## Classifications

### • Sub-arc flux

EN ISO 14174 - 2012 : SA AB 1 66 AC

### • Flux/Wire-combination

EN ISO 24598 : S CrMo1 AB (KD-B2)

: S CrMo2 AB (KD-B3)

AWS A5.23-2015: F8PZ-EB2-B2 (KD-B2)

: F9PZ-EB3-B3 (KD-B3)

### • SAW solid wire

EN ISO 24598 : S CrMo1 AB (KD-B2)

: S CrMo2 AB (KD-B3)

AWS A5.23-2015 : EB2 / EB3

## Description

- Single or multi-layer welding of various kinds structure such as 1.25%-0.5%Mo and 2.25%Cr-1%Mo heat resistant steels used for steam pipes of boiler, equipment for oil refining industries., etc.
- Bead appearance and slag removal are excellent under higher welding speed with low current.
- Good resistance to rust, scale, oil and dirt on th surface to be welded.
- Excellent X-ray characteristics and resistance to porosity.
- 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 (%)

Wire	C	Si	Mn	Cr	Mo
KD-B2	0.06	0.25	0.90	1.10	0.50
KD-B3	0.06	0.30	0.90	2.10	0.95

## Typical mechanical properties of all-weld metal

Wire	Y.S. (MPa)	T.S. (MPa)	El. (%)	Charpy V-notch		AWS Classification
				Temp.(℃)	Value(J)	
KD-B2	550	600	27	-18	80	A5.23 : F8PZ-EB2-B2*
KD-B3	610	690	23	0	50	A5.23 : F9PZ-EB3-B3*

\* PWHT : Post Weld Heat Treatment (690℃×1Hr.)