

EF-200H×KD-60

For 0.5%Mo heat resistant 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 - 2015 : F8P0-EA3-A3

KS B ISO 14171 : S 50 4 CS SZ

JIS Z 3183 : S572-M

• SAW solid wire

EN ISO 14171 - 2010 : SZ

AWS A5.23 - 2015 : EA3

Description

- Single and multi-layer welding of 0.5%Mo steel for pressure vessels, steam pipes, boilers., etc.
- Neutral flux for multi-pass welding.
- Excellent impact toughness 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	Mo	P	S
0.08	0.15	1.60	0.50	0.024	0.008

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-18℃	-40℃	
AWS A5.23	min. 470	550~700	min. 20	≥ 27		
EN ISO 14171	min. 500	560~720	min. 18	≥ 47		
Example	590	660	27	140	80	AW PWHT
	570	640	30	150	90	

* AW : As-Welded, PWHT : Post Weld Heat Treatment (620℃x1Hr.)