

EF-200H×KD-B3

For 2.25%Cr-1%Mo heat resistant steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA CS 1 53 AC

• Flux/ Wire-combination

EN ISO 24598-A:2008 : S CrMo2 CS

EN ISO 24598-B:2008 : S 62 2 CS SU 2C1M

AWS A5.23-2015 : F9P0-EB3-B3

KS B ISO 24598-A : S CrMo2 CS

KS B ISO 24598-B : S 62 2 CS SU 2C1M

JIS Z 3183 : S642-2CM

• SAW solid wire

EN ISO 24598-A:2008 : S CrMo2

EN ISO 24598-B:2008 : SU 2C1M

AWS A5.23 - 2015 : EB3

Description

- Single and multi-layer welding of 2.25%Cr-1%Mo steel for pressure vessels, oil refining industries, steam pipes of boiler., 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°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	Cr	Mo
0.08	0.27	0.90	2.26	0.92

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-18°C	-20°C	
AWS A5.23	min. 540	620~760	min. 17	≥ 27		
EN ISO 24598-B	min. 540	620~760	min. 15	≥ 27		
Example	610	700	23	70	70	PWHT

* PWHT : Post Weld Heat Treatment (690°Cx1Hr.)