

Classifications

- **Sub-arc flux**

EN ISO 14174 - 2012 : SA CS 2 DC

Description

- EF-200F is a basic and agglomerated flux used for hardfacing in combination with composite wires for hardfacing such as K-13CrHT.
- Typical applications : steel mills concast rolls, valve seats and components subject to wear, fatigue and corrosion at high temperature.
- Outstanding slag release properties and bead profile.
- Redry the flux at 250~350°C for 60 minutes before use
- The flux is suitable for single, multi-pass and oscillated welding, using single or twin-wire processes.
- Hardness of weld metal may be changed according to base metal, layer height, number of weld pass, welding condition., etc.

Typical chemical composition of all-weld metal (%)

Wire	C	Si	Mn	Cr	Ni	Mo	HRC
K-13CrHT	0.12	0.4	1.2	13.0	2.7	1.0	40~45
K-15CrHT	0.06	0.4	1.1	15.0	2.8	1.0	20~25

Recommended welding parameters

Dia. (mm)	Amp. (A)	Vol. (V)
3.2	400~700	26~36
4.0	450~900	28~38