EF-100xKD-50

For mild steel and 490MPa steel

Classifications

- **Sub-arc flux**
  EN ISO 14174 - 2012 : SA RS 1 81 AC
- **Flux/ Wire-combination**
  EN ISO 14171 - 2010 : S 46 0 RS S4
  AWS A5.17 - 2015 : F7A(P)0-EH14
  KS B ISO 14171 : S 46 0 RS S4
  JIS Z 3183 : S502-H
- **SAW solid wire**
  EN ISO 14171 - 2010 : S4
  AWS A5.17 - 2015 : EH14

Description

- Single and multi-layer welding of H-beams, spiral pipes, machinery, bridges and structural steels.
- Bead appearance and slag removal are excellent under higher welding speed with low current.
- Good resistance to porosity on rust and primer.
- 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.

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S
0.09	0.47	1.25	0.023	0.011

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) 0℃	IV (J) -18℃	Remarks
AWS A5.17	min. 400	480~660	min. 22		≥ 27	
EN ISO 14171	min. 460	530~680	min. 20	≥ 47		
Example	530	600	29	80	60	AW

* AW : As-Welded

Approvals

ABS	BV	DNV	LR	KR	NK	CCS
2YTM	A2YTM	IIYTM	2YTM	2YTM	KAW52TM	2YTM