

EF-100H×KD-50

For mild steel and 490MPa steel

Classifications

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|---------------------------------|-----------------|-------------------------|--------|
| • Sub-arc flux | | • SAW solid wire | |
| EN 756-1996 | : SA AB 1 72 AC | EN 756-2004 | : S4 |
| • Flux/ Wire-combination | | AWS A5.17-97 | : EH14 |
| EN 756-2004 | : S 46 3 AB S4 | | |
| AWS A5.17-97 | : F7A(P)2-EH14 | | |
| KS B 0531 | : S502-H | | |
| JIS Z 3183 | : S502-H | | |

Description

- Single and multi-layer welding of ship buildings, bridges, structural steels and other fabrications.
- 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	P	S
0.09	0.29	1.42	0.025	0.011

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-29°C	-30°C	
AWS A5.17	min. 400	480~660	min. 22	≥ 27		
EN 756	min. 460	530~680	min. 20		≥ 47	
Example	560	605	28	100	100	AW

* AW : As-Welded

Approvals

ABS	BV	DNV	GL	LR	KR	NK
3YM, 2YT	A3YM, A2YT	IIIYM, IITY	3YM, 2YT	3YM, 2YT	3YM, 2YT	KAW53M