

EF-100H×KD-60

For 560MPa high tensile strength steel

Classifications

• Sub-arc flux

EN 760-1996 : SA AB 1 72 AC

• Flux/ Wire-combination

EN 756-2004 : S 50 3 AB S4Mo

AWS A5.17-97 : F8A(P)4-EA3-G

KS B 0531 : S584-H

JIS Z 3183 : S584-H

• SAW solid wire

EN 756-2004 : S4Mo

AWS A5.17-97 : EA3

Description

- Single and multi-layer welding of 560MPa high tensile strength steels for structural steels, pipes, ship buildings and general fabrications.
- 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°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	Mo	P	S
0.06	0.35	1.40	0.47	0.022	0.012

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-40°C	
AWS A5.23	min. 470	550~700	min. 20		≥ 27	
EN 756	min. 500	560~720	min. 18	≥ 47		
Example	610	660	27	90	70	AW

* AW : As-Welded