

EF-100SxKD-42

For mild steel and 490MPa steel

Classifications

• Sub-arc flux

EN 756-1996 : SA AB 1 77 AC

• Flux/ Wire-combination

EN 756-2004 : S 46 2 AB SZ

AWS A5.17-97 : F7A(P)2-EM12K

KS B 0531 : S502-H

JIS Z 3183 : S502-H

• SAW solid wire

EN 756-2004 : SZ

AWS A5.17-97 : EM12K

Description

- Active flux for limited pass welding of ship buildings, steel frames, structures and bridges.
- Bead appearance and slag removal are excellent under higher welding speed with low current.
- Good resistance to porosity on rust and primer
- High speed on dirty plate
- 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
0.05	0.55	1.60	0.025	0.012

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-29°C	
AWS A5.17	min. 400	480~660	min. 22		≥ 27	
EN 756	min. 460	530~680	min. 20	≥ 47		
Example	545	600	29	70	50	AW

* AW : As-Welded