

# EF-100×KD-50

For mild steel and 490MPa steel

## Classifications

- **Sub-arc flux**  
EN 756-1996 : SA RS 1 81 AC
- **Flux/ Wire-combination**  
EN 756-2004 : S 46 0 RS S4  
AWS A5.17-97 : F7A(P)0-EH14  
KS B 0531 : S502-H  
JIS Z 3183 : S502-H
- **SAW solid wire**  
EN 756-2004 : S4  
AWS A5.17-97 : 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°C 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)		Remarks
				0°C	-18°C	
AWS A5.17	min. 400	480~660	min. 22	≥ 27		
EN 756	min. 460	530~680	min. 20	≥ 47		
Example	530	600	29	80	60	AW

\* AW : As-Welded

## Approvals

ABS	BV	DNV	GL	LR	KR	NK
2YTM	A2YTM	II YTM	2YTM	2YTM	2YTM	KAW52TM

\* Others : CCS