

EF-200H×KD-60

For 0.5%Mo heat resistant steel

Classifications

• Sub-arc flux

EN 756-1996 : SA CS 1 53 AC

• Flux/Wire-combination

EN 756-2004 : S 50 4 CS S4Mo

AWS A5.23-07 : F8P0-EA3-A3

KS B 0531 : S572-M

JIS Z 3183 : S572-M

• SAW solid wire

EN 756-2004 : S4Mo

AWS A5.23-07 : EA3

Description

- Single and multi-layer welding of 0.5%Mo steel for pressure vessels, steam pipes, boilers., etc.
- Neutral flux for multi-pass welding.
- 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	Mo	P	S
0.08	0.15	1.60	0.50	0.024	0.008

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-18°C	-40°C	
AWS A5.23	min. 470	550~700	min. 20	≥ 27		
EN 756	min. 500	560~720	min. 18		≥ 47	
Example	590	660	27	140	80	AW
	570	640	30	150	90	PWHT

* AW : As-Welded, PWHT : Post Weld Heat Treatment (620°Cx1Hr.)