

# EF-200H×KD-B2

For 1.25%Cr-0.5%Mo heat resistant steel

## Classifications

• <b>Sub-arc flux</b>		• <b>SAW solid wire</b>	
EN 756-1996	: SA CS 1 53 AC	EN SO 24598-A:2008	: S CrMo1
• <b>Flux/Wire-combination</b>		EN ISO 24598-B:2008	: SU 1CM
EN ISO 24598-A:2008	: S CrMo1 CS	AWS A5.23-07	: EA2
EN ISO 24598-B:2008	: S 55 2 CS SU 1CM		
AWS A5.23-07	: F8P0-EB2-B2		
KS B 0531	: S572-1CM		
JIS Z 3183	: S572-1CM		

## Description

- Single and multi-layer welding of 1.25%Cr-0.5%Mo steel for oil refining equipment, boiler drums, main steam tubes, chemical engineering apparatus., 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	Cr	Mo
0.10	0.18	0.90	1.11	0.48

## Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-18°C	-20°C	
AWS A5.23	min. 470	550~700	min. 20	≥ 27		
EN ISO 24598-B	min. 470	560~700	min. 18	≥ 27		
Example	590	650	27	100	100	PWHT

\* PWHT : Post Weld Heat Treatment (690°Cx1Hr.)