

EF-200×KD-40(41)

For mild steel and 490MPa steel

Classifications

- **Sub-arc flux**
EN 760-1996 : SA AB 1 69 AC
- **Flux/ Wire-combination**
EN 756-2004 : S 42 4 AB SZ
AWS A5.17-97 : F7A(P)4-EL8(EL12)
KS B 0531 : S502-H
IS Z 3183 : S502-H
- **SAW solid wire**
EN 756-2004 : SZ
AWS A5.17-97 : EL8(EL12)

Description

- Active flux for limited pass welding of ship buildings, bridges, structural steels and general fabrications.
- Excellent impact toughness and crack resistibility.
- Applicable to one-side welding.
- Suitable for welding of thick plate in both side single-layer welding.
- Applicable to both AC and DC(+)
- Redry the flux at 250~350℃ for 60 minutes before use.
- Excessive flux height may bring out poor bead appearance.

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S
0.06	0.28	1.35	0.024	0.012

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-30℃	-40℃	
AWS A5.17	min. 400	480~660	min. 22		≥ 27	
EN 756	min. 420	500~640	min. 20		≥ 47	
Example	470	550	32	100	80	AW

* AW : As-Welded

Approvals

ABS	BV	DNV	GL	LR	KR	NK
3YTM	A3YTM	IIIYTM	3YTM	3YTM	3YTM	KAW53TM