

# EF-200VxKD-EH12K

For mild steel and 490MPa steel

## Classifications

### • Sub-arc flux

EN ISO 14174 - 2012 : SA CS 1 53 AC

### • Flux/ Wire-combination

EN ISO 14171 - 2010 : S 46 6 CS S3Si

AWS A5.17 - 2015 : F7A(P)8-EH12K

KS B ISO 14171 : S 46 6 CS S3Si

JIS Z 3183 : S502-H

### • SAW solid wire

EN ISO 14171 - 2010 : S3Si

AWS A5.17 - 2015 : EH12K

## Description

- Single and multi-layer welding of various kinds of structures such as offshore structures, machinery, ship buildings, large diameter and heavy wall steel pipes.
- Neutral flux for multi-pass welding.
- Excellent impact toughness at low temperature.
- Bead appearance and slag removal are excellent.
- Applicable to both AC and DC(+)
- Redry the flux at 250~350°C 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
0.08	0.35	1.75	0.024	0.008

## Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-60°C	-62°C	
AWS A5.17	min. 400	480-660	min. 22	≥ 27	≥ 27	
EN ISO 14171	min. 460	530-680	min. 20	≥ 47	≥ 27	
Example	550	590	30	100	100	AW

\* AW : As-Welded