

EF-200LT Plus^xKD-EH12K

For low temperature service steel (490MPa)

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA CS 1 53 AC H5

• 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, pressure vessels, large diameter and heavy wall steel pipe and ship buildings.
- Excellent impact toughness at low temperature down to -60°C
- Outstanding welding characteristic and bead profile
- Neutral flux for multi-pass welding.
- 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	Ti	B
0.08	0.35	1.70	0.02	0.003

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	
EN ISO 14171	min. 460	530~680	min. 20	≥ 47		
Example	520	570	30	100	100	AW

* AW : As-Welded