

# EF-200LT×KD-60

For low temperature service steel (560MPa)

## Classifications

- Sub-arc flux  
EN ISO 14174 - 2012 : SA CS 1 53 AC H5
- Flux/ Wire-combination  
EN ISO 14171 - 2010 : S 50 5 CS SZ  
AWS A5.23 - 2015 : F9A8-EA3-G  
KS B ISO 14171 : S 50 5 CS SZ  
JIS Z 3183 : S584-H
- SAW solid wire  
EN ISO 14171 - 2010 : SZ  
AWS A5.23 - 2015 : EA3

## Description

- Single and multi-layer welding of 650MPa high tensile strength steels for low temperature service (offshore structures, steel pipes, chemical vessels and other structures in cold regions)
- Excellent impact toughness at low temperature down to -60°C
- Neutral flux for multi-pass welding.
- 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	Mo	Ti	B
0.07	0.14	1.50	0.46	0.02	0.004

## Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-50°C	-62°C	
AWS A5.23	min. 540	620~760	min. 17	≥ 47	≥ 27	AW
EN ISO 14171	min. 500	560~720	min. 18	≥ 47	≥ 27	
Example	590	650	26	70	60	

\* AW : As-Welded

## Approvals

ABS	BV	DNV	LR	NK	RINA
5YQ500M H5	A5Y50M H5	VY50M H5	5Y50M H5	KAW5Y50M	KAW5Y50M H5