

EF-200HxKD-B2

For 1.25%Cr-0.5%Mo heat resistant steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA CS 1 53 AC

• Flux/Wire-combination

EN ISO 24598-A:2008 : S CrMo1 CS

EN ISO 24598-B:2008 : S 55 2 CS SU 1CM

AWS A5.23-2015 : F8P0-EB2-B2

KS B ISO 24598-A : S CrMo1 CS

KS B ISO 24598-B : S 55 2 CS SU 1CM

JIS Z 3183 : S572-1CM

• SAW solid wire

EN ISO 24598-A:2008 : S CrMo1

EN ISO 24598-B:2008 : SU 1CM

AWS A5.23 - 2015 : EB2

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.)