FOR HIGH TENSILE STRENGTH STEEL

AWS F7A(P)2-EH14
JIS S502-H
KS FS-BN1×YS-S6

EF-100H×KD-50

Typical applications

Welding of general steel structures such as ships, structural steels, and other fabrications.

Characteristics on Usage

① Bead appearance and slag removal are excellent under higher welding speed with low current.
② Suitable for single or multi-layer welding of one side or both sides of steel plates.
③ Excellent impact properties and beautiful bead appearance.
④ Redry the flux at 250~350℃ for more than 60 minutes.

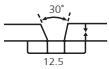
Typical chemical composition of all-weld-metal (%)

C	Si	Mn	S	P	Base metal	
					Class	Thick (mm)
0.08	0.34	1.50	0.012	0.011	SM490	25

Typical mechanical properties of all-weld-metal

Y · P	T · S	El	Charpy V-notch J (kgf · m)		Base metal	
N/mm²{kgf/mm²}	N/mm²{kgf/mm²}	(%)	-20℃	-30℃	Class	Thick (mm)
531 {54}	585 {60}	30	80 {8}	70 {7}	SM490	25

Typical welding conditons

Thick (mm)	Wire dia. (mm)	Groove dimension (mm)	Pass	Amp.	Volt.	Travel speed (cm/min)
25	4.0		1~14	600	30	40~50

Approved by

ABS, BV, DNV, GL, KR, LR, NK