EF-100H×KD-60

AWS F8A(P)4-EA3-G
JIS S584-H
KS FS-BN1×YS-M5

FOR HIGH TENSILE STRENGTH STEEL

Typical applications

Welding of vessels, steel structures, shipbuildings and pipes.

Characteristics on Usage

① Bead appearance and slag removal are excellent under higher welding speed with low current
② Excellent resistance against porosity and impact properties.
③ Repeated use of fluxes causes the deterioration of original performance of flux, so flux should be used by mixing new one properly.
④ Redry the flux at 250~350℃ for more than 60 minutes.

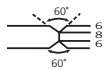
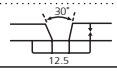
Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Mo	Base metal	
				Class	Thick (mm)
0.07	0.23	1.14	0.47	API X65	20

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℃	Class	Thick (mm)
560 {57}	640 {65}	29	70 {7}	API X65	20

Typical welding conditons

Thick (mm)	Wire dia. (mm)	Groove dimension (mm)	Pass		Amp.	Volt.	Travel speed (cm/min)
19	4.0		1st	L	770	33	110
				T	640	39	
			2nd	L	1050	33	120
				T	740	41	
25	4.0		1~14		600	30	40~50

Approved by