

# EF-200H/KD-60

AWS F8 PO-EA3-A3  
JIS S572-M

FOR HEAT-RESISTING STEEL

## Typical applications

Single or multi-pass submerged arc welding of 0.5%Mo steel used for pressure vessels and boilers.

## Characteristics on Usage

- ① Bead appearance and slag removal are excellent.
- ② Excellent impact properties and resistance against porosity.
- ③ Redry the flux at 250~350°C for more than 60 minutes.
- ④ Excessive flux height may bring out poor bead appearance.

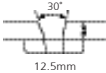
## Typical chemical composition of all-weld-metal (%)

C	Mn	Si	S	P	Mo	Cu
0.08	1.62	0.15	0.013	0.013	0.49	0.08

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	Charpy V-notch J {kgf · m}		Base metal		
			-40°C	-50°C	Class	Thick (mm)	PWH
581 {59}	639 {64}	31	70 {7}	50 {5}	ASTM A161:	25	620°CX1hr

## Typical welding conditions

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

Approved by