

FOR HEAT-RESISTING STEEL

AWS F8P0-EB2-B2
JIS S572-1CM

EF-200H/KD-B2

Typical applications

Single or multi-pass submerged arc welding of 1.25%Cr-0.5%Mo steel. used for oil refining equipment, fossil power equipment, etc.

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.

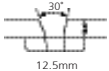
Typical chemical composition of all-weld-metal (%)

C	Mn	Si	S	P	Cr	Mo	Cu
0.07	0.75	0.21	0.010	0.011	1.11	0.44	0.10

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m}		Base metal		
			-18°C	-29°C	Class	Thick (mm)	PWHT
546 {55}	617 {62}	27	65 {6}	50 {5}	ASTM A387	25	690°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