

# EF-200×KD-40

**AWS** F7A(P)4-EL8/12  
**JIS** S502-H  
**KS** FS-BN1×YS-51

FOR HIGH TENSILE  
STRENGTH STEEL

## Typical applications

Welding of general structures such as ships, structural steels and general fabrications. Suitable for single or multi-layer welding of one side or both sides of steel plates in I groove, Y groove, X groove and U(V)groove.

## Characteristics on Usage

- ① Excellent slag removal and usability at high currents.
- ② Excellent impact properties and beautiful bead appearance.
- 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°C for more than 60 minutes.

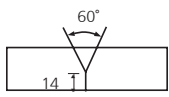
## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S	Base metal	
					Class	Thick (mm)
0.09	0.53	1.25	0.015	0.012	SM 490	20

## 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> }	El (%)	Charpy V-notch J {kgf · m}		Base metal	
			-30°C	-40°C	Class	Thick (mm)
470 {48}	550 {56}	28	90 {9}	80 {8}	SM 490	20

## Typical welding conditons

Thick (mm)	Wire dia. (mm)	Groove dimension (mm)	Amp.	Volt.	Travel speed (cm/min)
20	4.8		820	32	35

## Approved by

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