

**FOR HIGH TENSILE
STRENGTH STEEL**

**AWS F8A(P)6-EA3-G
JIS S584-H
KS FS-BN1/YS-M5**

EF-260/KD-60

Typical applications

Single and multi-layer welding of 590N/mm² class high tensile steel such as steel structures, pipes and machinery

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.

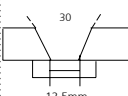
Typical chemical composition of all-weld-metal (%)

C	Si	Mn	S	P	Mo	Base metal	
						Class	Thick (mm)
0.05	0.13	1.41	0.012	0.014	0.48	SM 570TMC	25

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}		Remark
			-40°C	-50°C	
640 {65}	685 {69}	27	100 {10}	80 {8}	As-welded
604 {61}	642 {65}	29	112 {11}	94 {9}	PWHT(620°C*1hr.)

Typical welding conditions

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

Approved by