

EF-100S×KD-41/KD-43

For mild steel and 490MPa steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA AB 1 77 AC

• Flux/Wire-combination

EN ISO 14171 - 2010 : S 42 0 AB S1 / S 46 2 AB SZ

AWS A5.17 - 2015 : F7A0-EL12 / F7A2-EM13K

KS B ISO 14171 : S 42 0 AB S1 / S 46 2 AB SZ

JIS Z 3183 : S502-H

• SAW solid wire

EN ISO 14171 - 2010 : S1 / SZ

AWS A5.17 - 2015 : EL12 / EM13K

Description

- Active flux for limited pass welding of ship buildings, steel frames, structures and bridges.
- Bead appearance and slag removal are excellent under higher welding speed with low current.
- Good resistance to porosity on rust and primer
- High speed on dirty plate
- Applicable to both AC and DC(+)
- Redry the flux at 250~350°C for 60 minutes before use.
- Add new flux periodically when continuously reusing the flux.
- Excessive flux height may bring out poor bead appearance.

Typical chemical composition of all-weld metal (%)

Wire	C	Si	Mn	P	S
KD-41	0.04	0.37	1.10	0.021	0.014
KD-43	0.04	0.80	1.65	0.022	0.012

Typical mechanical properties of all-weld metal

Wire	Y.S. (MPa)	T.S. (MPa)	El. (%)	Charpy V-notch		AWS Classification
				Temp. (°C)	Vaule (J)	
KD-41	450	530	30	-18	60	A5.17 : F7A0-EL12
KD-43	560	610	28	-18	70	A5.17 : F7A0-EM13K