

KD-B3 x EF-200H

For 2.25%Cr-1%Mo heat resistant

Classifications

Sub-arc flux:

EN ISO 14174-2012 : SA CS 1 53 AC

Flux/Wire combination:

EN ISO 24598-A:2008 : S CrMo2 CS
 EN ISO 24598-B:2008 : S 62 2 CS SU 2C1M
 AWS A5.23-2015 : F9P0-EB3-B3
 KS B ISO 24598-A : S CrMo2 CS
 KS B ISO 24598-B : S 62 2 CS SU 2C1M
 JIS Z 3183 : S642-2CM

SAW solid wire:

EN ISO 24598-A:2008 : S CrMo2
 EN ISO 24598-B:2008 : SU 2C1M
 AWS A5.23-2015 : EB3

Description

- Single and multi-layer welding of 2.25%Cr-1%Mo steel for pressure vessels, oil refining industries, steam pipes of boiler., etc
 - Neutral flux for multi-pass welding
 - Excellent impact toughness and crack resistibility
 - Outstanding welding characteristics and bead profile
 - Applicable to both AC and DC(+)
 - Redry the flux at 250~350 for 60 minutes before use
- Add new flux periodically when continuously reusing the flux
- Excessive flux height may bring out poor bead appearance

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	Cr	Mo
0.08	0.27	0.90	2.26	0.92

Typical mechanical properties of all-weld metal

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J)		Remarks
				-18°C	-20°C	
AWS A5.23	Min. 540	620-760	Min. 17	≥ 27		
EN ISO 24598-B	Min. 540	620-760	Min. 15		≥ 27	
Example	610	700	23	70	70	PWHT

*PWHT: Post Weld Heat Treatment (690°C x1Hr.)

Sizes available and recommended currents (DC +)

Diameter	(mm)	2.4	3.2	4.0	4.8
Ampere	A	250-500	300-650	400-1200	500-1400
Volt	V	28-32	28-32	30-34	32-36