

# VENVU KD42/EF200K

## Prior Welding

SAW wire/flux combination, non-alloyed

### Classifications

EN ISO 14171-A	AWS A5.17
S 4 2 3 AR S2	F7A2-EM12

### Characteristics and typical fields of application

KD42/EF200K is a wire -flux combination for submerged -arc welding of unalloyed steel grades. It is used in general purpose applications in structural steel and pipe. It can be used for single - and multi-wire welding with high welding speed using the two -run technique as well as for fllet welding. The flux is donating Mn and Si to the weld pool ( desoxidation ) and therefore it is less sensitive for porosity issues due to dirt and rust on the plate. Most suitable for single run or 2 -run procedures. Multi-run procedures should be limited to weld thickness of max 20 mm. For higher wall thickness EF200LT Plus or to be preferred. Very good slag detachability and nice bead appearance.

### Base materials

General and fine grained structural steels, shipbuilding steels, pipe steels up to 420 MPa minimum yield strength.

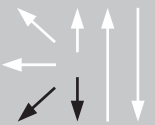
### Typical analysis of all-weld metal (wt.-%)

	C	Mn	Si
Wire	0.10	1.00	0.10
Weld metal	0.06	1.40	0.60

### Mechanical properties of all-weld metal – typical values (minimum values)

Heat-treatment	Yield strength Re	Tensile strength Rm	Elongation A (Lo=5d0)	Impact work ISO -V (J) (Average value from 3 test results)		
	MPa	MPa	%	20°C	-20°C	-30°C
AW	500 (≥ 420)	580 (≥ 530)	26 (≥ 22)	≥ 60	65 (≥ 47)	≥ 47

### Operating data

	<b>Polarity:</b> DC / AC
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### Approvals

TÜ V (2590) • DB (51.132.04) • ABS (2YM) • DNV -GL (IIIV TM) • LR ( 2YM)