

VENVU KD 42/EF200LT plus Prior Welding

Classifications			
SAW solid wire		SAW flux	
EN ISO 14171-A	EN ISO 14171-B	AWS A5.17	EN ISO 14174
S2	SU22	EM12K	SA AB 1 67 AC H5
SAW wire/flux combination			
EN ISO 14171-A	EN ISO 14171-B	AWS A5.17	AWS A5.17M
S 38 4 AB S2	S43A4 AB SU22	F7A4 -EM12 (F6P4 -EM12)	F48A4 -EM12 (F43P4 -EM12)

Characteristics and typical fields of application

Wire/flux combination for joint welding of unalloyed, ne grained and pipeline steel. EF200LT Plus is an agglomerated, aluminate -basic flux. Its characteristic is a low Silicon and a middle Manganese pickup. It can be used on AC and DC. The good weld ability and the good mechanical properties oer a universal application. For information regarding EF200LT plus see our detailed data sheet.

Base materials

Steels up to a yield strength of 380 MPa (56 ksi)
 S235JR -S355JR, S235JO -S355JO, S235J2 -S355J2, S275N -S355N, S275M -S355M, S275NL - S355NL, S275ML -S355ML, P235GH -P355GH, P275NL1 -P355NL1, P275NL2 -P355NL2, P215NL, P265NL, P355N, P285NH -P355NH, P195TR1 -P265TR1, P195TR2 -P265TR2, P195GH -P265GH, L245NB -L360NB, L245 MB -L360MB, GE200 -GE240, ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1, LF2; A 414 Gr. A , B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 707 Gr. L1, L3; A 711 Gr. 1013; A 841 Gr. A, B, C; API 5 L Gr. B, X42, X52, X56

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

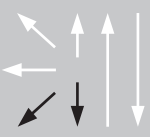
	C	Mn	Si
Wire	0.11	1.1	0.12
Weld metal	0.07	1.4	0.35

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

Heat-treatment	Yield strength Re	Tensile strength Rm	Elongation A (L ₀ =5d ₀)	Impact work ISO -V CVN J		
				20°C	0°C	-40°C
aw	400	480	22	120	100	47
s	355	480	25	140	120	47

s: stress relieved, 580 °C/5 hrs/Air

Operating data

	Ø (mm)	Polarity: DC (+) / DC (-)	Redrying of flux: 300 – 350 °C / 2 hrs min.
	2.0		
	2.5		
	3.0		
4.0			

Approvals

TÜV (06170) • DB (51. 132.03) • ABS • BV • GL • LR • DNV • CE