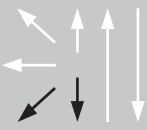


VENVU KD50/EF200LT Plus Prior Welding

SAW wire/flux combination, unalloyed

Classifications						
SAW solid wire			SAW flux			
EN ISO14171-A	EN ISO14171-B	AWS A5.17		EN ISO 14174		
S2Si	SU23	EM12K		SA AB 1 67 AC H5		
SAW wire/flux combination						
EN ISO14171-A	EN ISO14171-B	AWS A5.17		AWS A5.17M		
S 42 4 AB S2Si	S 49A4 AB SU23	F7A4 - EM12K / F7P6 - EM12K		F48A4 -EM12K		
Characteristics and typical fields of application						
<p>EF200LT Plus is an agglomerated welding flux of the aluminate basic type. It is suitable for single and pass welding. Good slag removability by butt and fillet welding. Grain size: EN ISO 14174: 3 – 20 (0.3 – 2.0 mm); Tyler: 8 x 48 Basicity (Boniszewski): 2.3 (Mol-%) / 1.7 (Weight-%) Main constituents in %: SiO₂ + TiO₂ = 20% / CaO + MgO = 30% / Al₂O₃ + MnO = 26% / CaF₂ = 16%</p>						
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	C	Mn	Si	P	S	
Wire	0.10	1.00	0.30	≤ 0.015	≤ 0.015	
Weld metal	0.06	1.45	0.45	≤ 0.020	≤ 0.015	
Mechanical properties of all-weld metal – typical values (minimum values)						
Heat-treatment	Yield strength	Tensile strength	Elongation	Impact work		
	Re	R _m	A (L ₀ =5d ₀)	ISO-V CVN J		
	MPa	MPa	%	20°C	-20°C	-40°C
AW	440	540	22	120	100	47
621 °C/1hr	420	510	22	160	120	50
620 °C/8hrs	370	480	22	180	150	100
Operating data						
	Ø (mm)	Polarity:	Redrying of flux:	Packing:	Voltage V	
	2.5	DC / AC	300 – 350 °C /	25 kg plastic bag	x – x	
	3.0		2 hrs min.		23 – 28	
	4.0					
Preheating and Interpass temperature as required by base material: 180 – 220 °C Heat Input 2,0 kJ/mm						
Approvals						
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