

S-777MXH × A-3

TYPE : Neutral

AWS A5.23 / ASME SFA5.23 F8A4-EA3-G
 JIS Z3183 S584-H
 EN ISO 14174 S A AB 1 / EN ISO 14171 S4Mo

SAW

Applications

Butt and flat fillet welding of miniature LPG tanks, ships, vehicles, agricultural implements, machinery, boilers, bridges and structural steels.

Characteristics on Usage

Especially insensitive to oil, rust, scale, dirt and primers on the surface to be welded. Slag detachability in narrow groove and resistance to porosity are excellent. As the consumption of flux is low, it is very economical. Applicable to horizontal and flat fillet welding.

Notes on Usage

- ① Dry the flux at 300~350° C (572~662° F) for 60 minutes before use.
- ② When the flux height is excessive, poor bead appearance may occur.
- ③ Remove rust, scales, oil, paint, water, dirt and slag of tack welds from the groove to obtain sound weld metal.
- ④ Use welding current and speed as low as possible at the first layer of groove to avoid cracking.

Approval	I Current	I Basicity Index
	AC, DC +	0.9

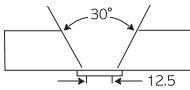
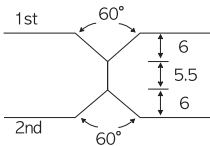
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
A-3	0.04	0.28	1.30	0.025	0.015	0.50	SM570	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	BM	Th.(mm)
A-3	630 (91,500)	660 (95,900)	26	-40 (-40)	40 (30)	SM570	25
	-	640 (93,000)	-	-20 (-4)	70 (52)	API5L × 65	17.5

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-3	4.0	25		1~13	570	30	40	AWS A5.23
A-3	L(DC+):4.0 T(AC):4.0	17.5		1st	(L)770 (T)640	32 40	110	Both Side Single-pass (tandem)
				2nd	(L)1050 (T)750	32 42	120	