

S-707T × H-14

TYPE : Neutral

AWS A5.17/ASME SFA5.17 F7A(P)6-EH14
JIS Z3183 S502-H
EN ISO 14174 S A AB 1 / EN ISO 14171 S4

Applications

Single-layer welding of shipbuildings.

Characteristics on Usage

As the penetration is deep, it is suitable for welding of thick plate in both side single-layer welding. It is suitable for single-pass-on-both-sides welding due to wide range of applicable welding conditions. Good bead appearance and excellent impact value of the weld metal. As the consumption of flux is low, it is very economical.

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 Use welding current and speed as low as possible at the first layer of groove to avoid cracking.

Approval	I Current	I Basicity Index
KR, ABS, LR, BV, DNV, GL , NK	AC, DC +	1.5

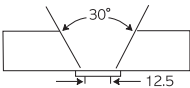
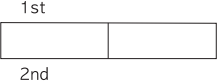
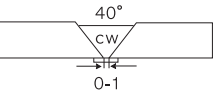
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.10	0.37	1.54	0.020	0.012	SS400	25
	0.14	0.41	1.43	0.018	0.008	EH36	20
	0.11	0.29	1.52	0.018	0.009	DH36	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS	TS	EL	Position of fracture	CVN-Impact Value J (ft · lbs)			BM	Th. (mm)
	MPa(lbs/in ²)	MPa(lbs/in ²)	(%)		0°C(32°F)	-20°C(-4°F)	-51°C(-60°F)		
H-14	570 (82,800)	605 (87,900)	28.0	-	-	-	80 (59)	SS400	25
	-	570 (82,800)	-	BM	-	50 (37)	-	EH36	20
	-	580 (84,200)	23.0	-	70 (52)	-	-	DH36	25

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks	
H-14	4.0	25		1-13	550	30	40	AWS A5.17	
H-14	4.8	20		1st	L(DC+)	1100	37	100	Tandem
					T(AC)	700	42		
				2nd	L(DC+)	1200	37	100	SL
					T(AC)	700	42		
H-14	4.8	25		1	1150	35	20	FAB OSW (DC+)	