

Superflux787 × H-12K

TYPE : Neutral

AWS A5.17/ASME SFA5.17 F7A(P)8-EH12K
JIS Z3183 S502-H
EN ISO 14174 S A FB 1 / EN ISO 14171 S3Si

Applications

Multi-layer welding of various kinds of structures such as ship buildings, offshore structures, machinery, pressure vessels, large diameter and heavy wall steel pipe.

Characteristics on Usage

An agglomerated fluoride-basic flux suitable for welded joints on high-tensile and fine-grained steels.

Tandem, multi-electrode welding can be performed. Because of insensitivity to rust, scale, primer on the surface to be welded, it has excellent X-ray characteristics and slag removal.

Notes on Usage

Dry the flux at 300~350°C(572~662° F) for 60 minutes before use.

Approval	I Current	I Basicity Index
	AC, DC +	2.5

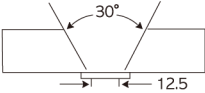
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-12K	0.09	0.30	1.50	0.018	0.010	AH36	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	PWHT condition	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	BM	Th. (mm)
H-12K	540 (78,400)	580 (84,200)	32.0	-	-62 (-80)	168 (124)	AH36	25
	450 (65,300)	520 (75,500)	33.0	620°C × 1hr	-62 (-80)	180 (133)	AH36	25

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-12K	4.0	25		1~13	570	30	40	AWS A5.17