

Superflux787 × H-14

TYPE : Neutral

AWS A5.17 / ASME SFA5.17 F7A(P)8-EH14
JIS Z3183 S502-H
EN ISO 14174 S A FB 1 / EN ISO 14171 S4

SAW

Applications

Multi-layer welding of various kinds of structure such as ship buildings, offshore structures, machinery and pressure vessels.

Characteristics on Usage

High-basic bonded type flux having excellent impact value at temperature below to -60 (-76° F) and good CTOD. Single and 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

① Dry the flux at 300~350° C (572~662° F) for 60 minutes before use.

Approval

KR, ABS, BV, DNV, GL, LR, NK, CCS

I Current

AC, DC +

I Basicity Index

2.5

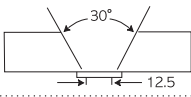
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.10	0.07	1.43	0.018	0.010	SS400	25
	0.06	0.13	1.37	0.016	0.007	SM490	39

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)
H-14	470 (68,200)	560 (81,300)	26	-62 (-80)	130 (96)	SS400	25
		-	-	-40 (-40)	80 (59)	SM490	39
	-	550 (76,800)	-	-62 (-80)	50 (37)		

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	570	30	40	AWS A5.17
H-14	4.0	39		1	500	28	35	} 1st
				2~7	600	32	30	
				8	500	28	35	} 2nd
				9~13	600	32	30	