Superflux55LP × H-14

TYPE : Neutral

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

Applications

Superflux 55LP x H-14 is multi-layer welding of various kinds of structure such as LPG ship buildings, offshore structures and pressure vessels.
Superflux 55LP x A-3 is single-layer welding of LPG ship buildings.

Characteristics on Usage

It produces the weld metal which has excellent impact value at low temperature down to -60˚C (-76˚F) and CTOD at low temperature. As the hydrogen content of weld metal is low, it shows excellent resistance to crack.

Notes on Usage

① Dry the flux at 300~350℃ (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
	AC, DC +	2.5

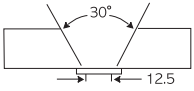
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
H-14	0.10	0.15	1.45	0.020	0.005	-	SS400	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Position of fracture	CVN-Impact Value J (ft · lbs) -51℃(-60˚F)	-55℃(-67˚F)	-62℃(-80˚F)	BM	Th. (mm)
H-14	495 (71,800)	560 (81,200)	29	-	-	-	150 (110)	SS400	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	570	30	40	AWS A5.17