

S-800MX × A-G[A-3]

TYPE : Neutral

AWS A5.23/ASME SFA5.23 F8A0-EG-G
KS (JIS) B0531 (Z3183) S502-H
AWS A5.23/ASME SFA5.23 F8AZ-EA3-G
KS (JIS) B0531 (Z3183) S582-H
EN ISO 14174 S A AR 1 / EN ISO 14171 S4[S4Mo]

Applications

Single and multi-layer welding of bridges, H-beam 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.
Suitable for tandem welding of H-Beam.
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
	AC, DC +	0.8

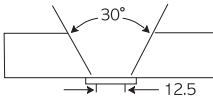
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	BM
A-G	0.09	0.40	1.20	0.025	0.010	-	SM520B
A-3	0.08	0.35	1.15	0.020	0.010	0.45	SM570

Typical Mechanical Properties of All-Weld Metal

Wire	YS	TS	EL	CVN-Impact Value J (ft · lbs)		BM
	MPa(lbs/in ²)	MPa(lbs/in ²)	(%)	-5°C(23°F)	-18°C(0°F)	
A-G	590 (85,600)	630 (91,400)	27	-	120 (89)	SM520B
A-3	650 (94,300)	690 (100,000)	25	80 (59)	-	SM570

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-G (A-3)	4.0	25		1~13	570	30	40	AWS A5.23