

S-460Y × H-14

TYPE : Neutral

AWS A5.23/ASME SFA5.23 F8A8-EH14-G
 KS(JIS) B0531(Z3183) S584-H
 EN ISO 14174 S A FB 1 / EN ISO 14171 S4

SAW

Applications

Multi-layer welding of high strength steels, such as EH47.

Characteristics on Usage

It produces the weld metal which has excellent impact value at low temperature service. Single and multi electrode welding can be performed. It has excellent X-ray characteristics and slag removal, because of insensitivity to rust, scale, primer on the surface to be welded.

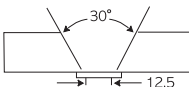
Notes on Usage

- 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.
- ④ Preheat the thick plate according to rules if it has heavy restricted stress.

Approval	I Current	I Basicity Index
KR, ABS, LR, BV, DNV, GL, NK	AC, DC +	2.5

Typical Chemical Composition of All-Weld Metal (%)						
Wire	C	Si	Mn	P	S	BM
H-14	0.10	0.28	1.50	0.020	0.005	SM570

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	610 (88,500)	640 (92,800)	27.0	-60 (-76)	100 (74)	SM570	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 A5.23