

Applications

One-side welding of ships, bridges and structural steels.

Characteristics on Usage

The usability with high heat input is suitable. As the deposition rate is high. It is very efficient. Suitable for one side welding of TMCP steel. Impact value of weld metal in the high heat input welding is high. Applicable to single or tandem electrode welding.

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 Add new flux periodically to prevent the weld defects and bad bead appearance which occurs when continuously reusing the flux.

Approval

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

I Current

AC, DC+

I Basicity Index

4.5

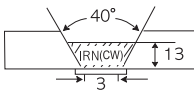
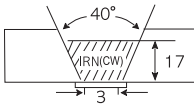
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
H-14	0.10	0.20	1.23	0.017	0.011	0.80	AH36	15
	0.10	0.21	1.29	0.014	0.010	0.90	AH36	20

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	430 (62,400)	560 (81,300)	23	0 (32)	60 (44)	AH36	15
	400 (58,000)	550 (79,800)	23	0 (32)	60 (44)	AH36	20

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.8	15		1	900	35	22	
H-14	4.8	20		1	1000	36	20	