

Applications

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

Characteristics on Usage

The usability with high heat input is good. As the deposition rate is high, it is very efficient.

Suitable for one side welding of TMCP steel.

Impact properties of weld metal in the high heat input welding are good.

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	I Current	I Basicity Index
KR, ABS, LR, BV, DNV, GL, NK	AC, DC +	4.2

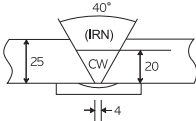
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	Ti	B	BM	Th.(mm)
H-14	0.103	0.26	1.44	0.014	0.006	0.021	0.028	0.0045	EH36	25

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	509 (73,800)	618 (89,600)	22.6	-20 (-4)	80 (59)	EH36	25

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.8	25		1	1000	36	16	