

S-707 X L-8

Type : Active

Conformances

AWS A5.17/ ASME SFA5.17 F7A4-EL8

JIS Z3352 SA AB1

EN ISO 14174-S A AB 1 / EN ISO 14171-A-S1

KR 3TM, 3YTM

ABS 3TM, 3YTM

LR 3TM, 3YTM

BV A3TM, A3YTM

DNV-GL IIIYTM

NK KAW3TM, KAW53TM

RINA 3YM, 3YT

RS 3YTM

Applications

- Shipbuilding

Features

- Both side single-layer welding
- Low consumption of flux
- Density : 1.1g/cm³

Current

AC, DC +

Basicity Index

1.6

Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%			
	SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
S-707	15	30	40	15

Diameter / Packaging

Diameter mm (in)	Spool			Basket						Coil				Pac				
	20kg (44lbs)	25kg (55lbs)	100kg (220lbs)	25kg (55lbs)	100kg (220lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	500kg (1102lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)	400kg (881lbs)				
1.6 (1/16)	✓																	
2.0 (5/64)	✓	✓																
2.4 (3/32)				✓														
3.2 (1/8)				✓														
4.0 (5/32)				✓	✓													
4.8 (3/16)				✓	✓					✓	✓							
6.4 (1/4)										✓	✓							

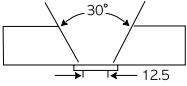
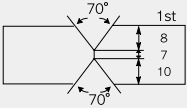
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
L-8	0.07	0.40	1.40	0.028	0.015	SS400	25
	0.08	0.32	1.29	0.015	0.014	AH36	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)
L-8	490 (71,000)	560 (81,000)	31	-40 (-40)	70 (52)	SS400	25
	-	570 (82,800)	-	-20 (-4)	40 (30)	AH36	25

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
L-8	4.0	25		1-13	570	30	40	AWS A5.17
L-8	4.8	25		1st 2nd	950 1100	34 37	40 30	Both side Single pass

SWAW

SAW

GM/AV

GTAW

FCAW

Non-FERROUS

APPENDIX