S-777MX X H-14

Type : Neutral

CE

Conformances

AWS A5.17/ ASME SFA-5.17 F7A0-EH14

JIS Z 3352 S A AR 1/JIS Z 3351 YS-S6/JIS Z 3183 S502-H

EN ISO 14174-S A AR 1 / EN ISO 14171-A-S4

KR 2M, 2YM

ABS 2M, 2YM

LR	2M, 2YM
BV	A2M, A2YM
DNV	IIYM
NK	KAW2M, KAW52M
CE	

Applications

- LPG tanks
- Spiral pipes
- Structural steels

Current

AC, DC+

Basicity Index

0.5

Features

- Good Slag detachability
- Good high-speed welding
- Horizontal and flat fillet welding
- Density : 1.0g/cm^3

Packages (Flux)

Tin CAN 20kg(44lbs)

Shield BAG 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%		
	$Al_2O_3 + TiO_2$	$Al_2O_3 + TiO_2$	$Al_2O_3 + TiO_2$
S-777MX	55	25	20

Diameter /Packaging

Diameter	Spool	Basket		Coil						Pac				
mm (in)	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)				√	√									

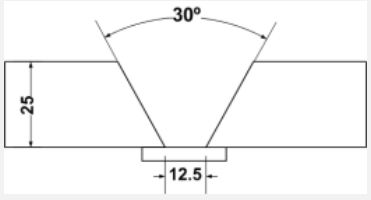
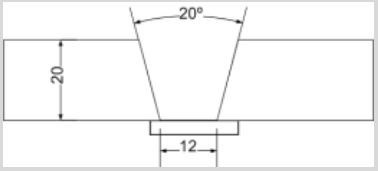
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.08	0.50	0.90	0.020	0.010	AH36	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in^2)	TS MPa(lbs/in^2)	EL (%)	Temp ℃(˚F)	CVN-Impact Value J(ft·lbf)	BM	Th.(mm)
H-14	560 (81,000)	620 (89,000)	27	-20 (0)	45 (35)	AH36	25
	-	530 (77,000)	-	0 (32)	70 (51)	SM490	20

Typical Operating Procedures

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.0	25		1-13	550	30	40	AWS A5.17
H-14	4.0	20		1-10	550	30	40	JIS Z 3183

S-777MX X A-G

Type : Neutral

CE

Conformances

AWS A5.23 / ASME SFA-5.23 F8A0-EG-G

JIS Z 3352 S A AR 1/JIS Z 3351 YS-S6/JIS Z 3183 S582-H

Applications

- LPG tanks
- Spiral pipes
- Structural steels

Features

- Good Slag detachability
- Good high-speed welding
- Horizontal and flat fillet welding
- Density : 1.0g/cm^3

Current

AC, DC+

Basicity Index

0.5

Packages (Flux)

Tin CAN 20kg(44lbs)

Sheild BAG 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%		
	$Al_2O_3 + TiO_2$	$Al_2O_3 + TiO_2$	$Al_2O_3 + TiO_2$
S-777MX	55	25	20

Diameter /Packaging

Diameter	Spool	Basket		Coil						Pac				
mm (in)	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)				√	√									

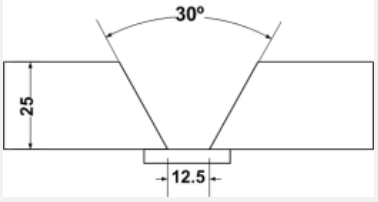
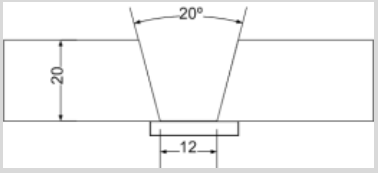
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
A-G	0.06	0.60	1.00	0.015	0.005	AH36	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in^2)	TS MPa(lbs/in^2)	EL (%)	Temp ℃(˚F)	CVN-Impact Value J(ft·lbf)	BM	Th.(mm)
A-G	510 (74,000)	610 (88,000)	30	-20 (0)	85 (64)	AH36	25
	580 (84,000)	640 (93,000)	27	-5 (23)	100 (73)	AH36	20

Typical Operating Procedures

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-G	4.0	25		1-14	550	30	40	AWS A5.17
A-G	4.0	20		1-10	550	30	40	JIS Z 3183