

# Superflux 787 X H-12K

Type : Neutral

## Conformances

AWS A5.17 / ASME SFA5.17 F7A(P)8-EH12K

JIS Z3352 SA FB1

EN ISO 14174-S A FB 1 / EN ISO 14171-A-S3Si

ABS 4YM H5

AWS A5.17 F7A(P)8-EH12K

## Applications

- Offshore
- Pressure vessels
- Pipeline

## Features

- Low hydrogen content
- Tandem, multi-electrode applicable
- Good impact value at low temperature after heat treatment
- Density : 1.2g/cm<sup>3</sup>

## Current

AC, DC +

## Basicity Index

2.7

## Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

## Flux Composition

Consumable	Chemical Composition, wt%		
	MgO + MnO	CaF <sub>2</sub> + CaO	Al <sub>2</sub> O <sub>3</sub> + SiO <sub>2</sub>
Superflux 787	35	35	30

## Diameter / Packaging

Diameter	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)	✓													
2.4 (3/32)				✓										
3.2 (1/8)				✓	✓	✓								
4.0 (5/32)				✓	✓	✓		✓	✓		✓	✓	✓	✓

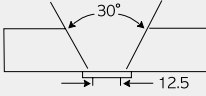
**Typical Chemical Composition of All-Weld Metal(%)**

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-12K	0.09	0.30	1.50	0.018	0.010	AH36	25

**Typical Mechanical Properties of All-Weld Metal**

Wire	YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	PWHT condition	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)	BM	Th.(mm)
H-12K	540 (78,400)	580 (84,200)	32.0	-	-62 (-80)	101 (75)	AH36	25
	450 (45,300)	520 (75,500)	33.0	620°C×1hr	-62 (-80)	110 (81)	AH36	25

**Typical Welding Parameters**

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-12K	4.0	25		1-13	570	30	40	AWS A5.17

SMW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX