

Superflux787 X A-2

Type: Neutral



Conformances

AWS A5.23/ ASME SFA-5.23 F8A(P)6-EA2-A2

JIS Z 3352 S A FB1 / JIS Z 3351 YS-M3

EN ISO 14174-S A FB 1 / EN ISO 14171-A-S2Mo

Applications

- Offshore
- Pressure vessels
- Pipeline

Features

- Low hydrogen content
- Tandem, Multi-electrode applicable
- Good impact value at low temperature
- Density : 1.2g/cm³

Current

AC, DC+

Basicity Index

2.7

Packages (Flux)

Tin CAN 20kg(44lbs)

Shield BAG 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%		
	MgO + MnO	CaF ₂ + CaO	Al ₂ O ₃ + SiO ₂
Superflux787	35	35	30

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)				✓	✓									

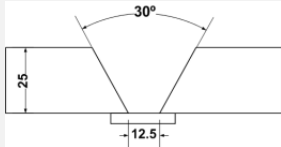
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
A-2	0.09	0.24	1.14	0.020	0.006	0.43	SM570	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·lbf)	BM	Th.(mm)
A-2	530 (77,000)	610 (88,000)	28	-50 (-60)	80 (60)	SM570	25

Typical Operating Procedures

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-2	4.0	25		1-13	550	30	40	AWS A5.23