

S-707 × L-8

TYPE : Active

AWS A5.17 / ASME SFA5.17 F7A4-EL8
 JIS Z3183 S502-H
 EN ISO 14174 S A AB 1 / EN ISO 14171 S1

SAW

Applications

Single-layer and multi-layer welding of shipbuildings.

Characteristics on Usage

As the penetration is deep, it is suitable for welding of thick plate in both side single-layer welding. Impact value (or mechanical properties) of weld metal and crack resistibility are excellent. Also applicable to one-side welding. As the consumption of flux is low, it is economical.

Notes on Usage

- ① Dry the flux at 300~350° C (572~662° F) for 60 minutes before use.
- ② Pay attention to welding voltage. Excessive welding voltage causes deterioration of joint properties.
- ③ Add new flux periodically to prevent the weld defects and bad bead appearance which occurs when continuously reusing the flux.
- ④ Weld pass should be limited to 3 or 4 passes. (please inquire of the manufactures when welding more than 5 passes)

Approval	I Current	I Basicity Index
KR, ABS, LR, BV, DNV, GL, NK, MRS	AC, DC +	1.6

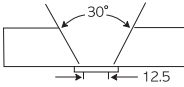
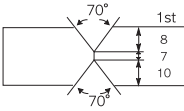
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
L-8	0.07	0.40	1.40	0.028	0.015	SS400	25
L-8	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 Conditions

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	950	34	40	Both side
				2nd	1100	37	30	Single pass