

S-777MXT × A-2[B-2]

TYPE : Neutral

AWS A5.23/ASME SFA5.23 F8PZ-EA2-A2
 AWS A5.23/ASME SFA5.23 F8PZ-EB2-B2
 EN ISO 14174 S A AR 1 / EN ISO 14171 S2Mo[S2CrMo1]

SAW

Applications

S-777MXT × A-2 is single or multi-layer welding of various kinds structure such as 0.5%Mo steels used for pressure vessels and boilers.

S-777MXT × B-2 is single or multi-layer welding of various kinds structure such as 1.25%Cr-0.5%Mo heat resistant steels used for steam pipes of boilers for electric power plant and marine use, equipment for oil refining industries.

Characteristics on Usage

An agglomerated Aluminate-rutile flux suitable for welded joints on 0.5%Mo steel, heat resistant steel.

Especially insensitive to rust, scale and dirt on the surface to be welded. slag detachability in narrow groove and resistance to porosity are excellent. Suitable for welding of thin and medium plate in high speed welding.

Welded, has excellent X-ray characteristics and slag removal.

Notes on Usage

Dry the flux at 350~400°C(662~752°F) for 60 minutes before use.

| Approval | I Current | I Basicity Index |
|----------|-----------|------------------|
| | AC, DC + | 0.5 |

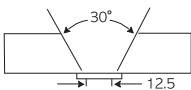
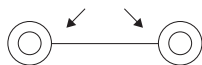
Typical Chemical Composition of All-Weld Metal (%)

| Wire | C | Si | Mn | P | S | Cr | Mo | BM | Th.(mm) |
|------|------|------|------|-------|-------|------|------|-----------|---------|
| A-2 | 0.05 | 0.68 | 0.75 | 0.020 | 0.010 | - | 0.46 | SM570 | 25 |
| B-2 | 0.05 | 0.68 | 0.75 | 0.020 | 0.010 | 1.06 | 0.44 | A387-Gr11 | 25 |

Typical Mechanical Properties of All-Weld Metal

| Wire | YS MPa(lbs/in ²) | TS MPa(lbs/in ²) | EL (%) | PWHT | CVN-Impact Value J (ft · lbs) 0°C (32°F) | BM | Th.(mm) |
|------|---------------------------------|---------------------------------|-----------|------------|---|------------|---------|
| A-2 | 580 (84,100) | 640 (92,800) | 28.0 | As welded | - | SM570 | 25 |
| B-2 | 630 (91,400) | 720 (104,400) | 20.8 | As welded | 32 (24) | A387-Gr.11 | 25 |
| B-2 | 560 (81,200) | 640 (92,800) | 25.0 | 690°C X1hr | 45 (33) | A387-Gr.11 | 25 |

Typical Welding Conditions

| Wire | Dia. (mm) | Th. (mm) | Groove Design (mm) | Pass | Amp. (A) | Volt. (V) | Speed (cm/min) | Remarks |
|--------------|--------------|-------------|---|------|-------------|--------------|-------------------|--------------------------|
| A-2 (B-2) | 4.0 | 25 |  | 1~13 | 570 | 30 | 40 | AWS A5.23 |
| B-2 | 2.4 | 12 |  | 1 | 400 | 28 | 200 | Fin tube of boiler |