

S-777MXT × H-14[M-12K]

TYPE : Neutral

AWS A5.17/ASME SFA5.17 F7A0-EH14
 AWS A5.17/ASME SFA5.17 F7A(P)Z-EM12K
 EN ISO 14174 S A AR 1 / EN ISO 14171 S4[S2Si]

Applications

Butt and flat welding of thin and medium thickness plates, high travel speed welding for miniature LPG tanks. Longitudinal pipes welding of, spiral pipes welding of thin and medium walled pipes.

Characteristics on Usage

An agglomerated Aluminate-rutile flux suitable for welded joints on heat resistant steel. Especially insensitive to oil, rust, scale, and dirt on the surface to be welded. Slag detachability in narrow groove and resistance to porosity are excellent.

Notes on Usage

- ① Dry the flux at 350~400°C(662~752°F) for 60 minutes before use.
- ② When the flux height is excessive, poor bead appearance may occur.

Approval	I Current	I Basicity Index
	AC, DC +	0.5

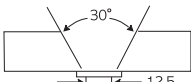
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.09	0.52	1.18	0.023	0.013	SS400	25
M-12K	0.06	0.52	0.73	0.024	0.016	SS400	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS	TS	EL	CVN-Impact Value J (ft · lbs)		BM	Th.(mm)
	MPa(lbs/in ²)	MPa(lbs/in ²)	(%)	0°C (32°F)	-18°C (0°F)		
H-14	550 (79,800)	600 (87,000)	29.8	65 (48)	30 (22)	SS400	25
M-12K	510 (74,000)	560 (81,200)	28.6	42 (31)	-	SS400	25

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14 (M-12K)	4.0	25		1~13	570	30	40	AWS A5.17