

S-777MX X H-14

Type : Neutral



Conformances

AWS A5.17/ ASME SFA5.17 F7A0-EH14
 JIS Z3352 SA AR1
 EN ISO 14174-S A AR 1 / EN ISO 14171-A-S4
 KR 2M, 2YM
 ABS 2M, 2YM

LR 2M, 2YM
 BV A2M, A2YM
 DNV-GL I1YM
 NK KAW2M, KAW52M
 CE

Applications

- LPG tanks
- Spiral pipes
- Agricultural implements

Features

- Easy to remove slag
- High speed welding
- Horizontal and flat fillet welding
- Density : 1.0g/cm³

Current

AC, DC +

Basicity Index

0.5

Packages (Flux)

Tin Can 20kg(44lbs)
 PE Bag 20kg(44lbs)

Flux Composition

| Consumable | Chemical Composition, wt% | | |
|------------|---|------------------------|-----------|
| | Al ₂ O ₃ + TiO ₂ | SiO ₂ + MnO | CaO + MgO |
| S-777MX | 55 | 25 | 20 |

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) | | | | ✓ | ✓ | | | | | | | | | |

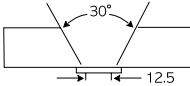
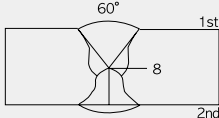
Typical Chemical Composition of All-Weld Metal(%)

| Wire | C | Si | Mn | P | S | BM | Th.(mm) |
|------|------|------|------|-------|-------|-------|---------|
| H-14 | 0.08 | 0.53 | 0.94 | 0.021 | 0.014 | SS400 | 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) |
|------|---------------------------------|---------------------------------|-----------|----------------|--------------------------------|-------|---------|
| H-14 | 560 (81,000) | 620 (90,000) | 27 | -18 (0) | 48 (35) | SS400 | 25 |
| | - | 530 (76,900) | - | -5 (23) | 72 (53) | SM490 | 20 |

Typical Welding Parameters

| Wire | Dia. (mm) | Th. (mm) | Groove Design (mm) | Pass | Amp. (A) | Volt. (V) | Speed (cm/min) | Remarks |
|------|--------------|-------------|---|------|-------------|--------------|-------------------|------------------------|
| H-14 | 4.0 | 25 |  | 1~13 | 570 | 30 | 40 | AWS A5.17 |
| H-14 | 4.8 | 20 |  | | 800 850 | 36 37 | 25 45 | Both Single pass |

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX