

S-777MX X H-14

Type : Neutral



Conformances

AWS A5.17 / ASME SFA5.17 F7A0-EH14
 JIS Z3352 S A AR 1 / Z3351 YS-S6 / Z3183 S502-H
 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)				✓	✓									

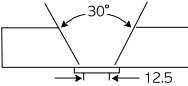
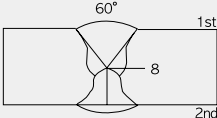
Typical Chemical Composition of All-Weld Metal(%)

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