

S-777MXH X H-14

Type : Neutral

Conformances

AWS A5.17/ ASME SFA5.17 F7A(P)2-EH14
 JIS Z3352 SA AB1
 EN ISO 14174-S A AB 1 / EN ISO 14171-A-S4
 KR 2T, 2YT, 3M, 3YM
 ABS 2T, 2YT, 3M, 3YM
 LR 3M, 3YM, 2T, 2YT

BV A2T, A2YT, A3M, A3YM
 DNV-GL IYTH10, IIIYM H10
 NK KAW3M, KAW53M
 KAW2T, KAW52T
 CWB CSA W48 F49A(P)3-EH14

Applications

- LPG tanks
- General fabrication
- Structural fabrication

Features

- Easy to remove slag
- High speed welding
- Horizontal and flat fillet welding
- Density : 1.2g/cm³

Current

AC, DC +

Basicity Index

0.9

Packages (Flux)

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

Flux Composition

Consumable	Chemical Composition, wt%		
	Al ₂ O ₃ + Fe ₂ O ₃	MgO + MnO	SiO ₂ + CaF ₂
S-777MXH	35	35	30

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)				✓	✓									

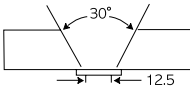
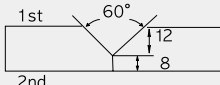
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.07	0.30	1.37	0.028	0.021	SS400	25
	0.12	0.30	1.43	0.024	0.012	SM490	20

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	520 (75,500)	570 (87,700)	30	-29 (-20)	120 (88)	SS400	25
	-	560 (81,300)	-	0 (32)	70 (52)	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		1st 2nd	800 850	34 36	25 25	Both Side Single-pass

SAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX