

S-777MXH X A-3

Type : Neutral

Conformances

AWS A5.23/ ASME SFA5.23 F8A4-EA3-A3
 JIS Z3352 SA AB1
 EN ISO 14174-S A AB 1 / EN ISO 14171-A-S4Mo

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)				✓	✓			✓						

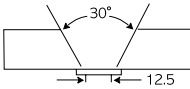
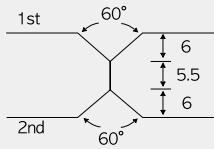
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
A-3	0.04	0.28	1.30	0.025	0.015	0.50	SM570	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)
A-3	630 (91,500)	660 (95,900)	26	-40 (-40)	40 (30)	SM570	25
	-	640 (93,000)	-	-20 (-4)	70 (52)	API5Lx65	17.5

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-3	4.0	25		1~13	570	30	40	AWS A5.23
A-3	L(DC+):4.0	17.5		1st	(L)770 (T)640	32 40	110	Both Side Single-pass (tandem)
	T(AC):4.0			2nd	(L)1050 (T)750	32 42		