

S-777MXT X H-14 [M-12K]

Type : Neutral

Conformances

AWS A5.17/ ASME SFA5.17 F7A0-EH14
 AWS A5.17/ ASME SFA5.17 F7A(P)Z-EM12K
 JIS Z3352 SA AR1
 EN ISO 14174-S A AR 1 / EN ISO 14171-A-S4 [S2Si]

Applications

- LPG tanks
- Boiler(Fin tube)

Features

- Easy to remove slag
- High speed 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 + Fe ₂ O ₃	TiO ₂ + MnO	SiO ₂ + CaO
S-777MXT	55	25	15

Diameter / Packaging

- H-14 : ✓
- M-12K : ○

Diameter	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)				✓	✓									

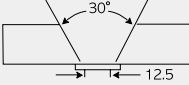
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.09	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 MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft-lbs)		BM	Th.(mm)
				0°C (32°F)	-18°C (0°F)		
H-14	550 (79,800)	600 (87,000)	29.8	65 (48)	41 (30)	SS400	25
M-12K	510 (74,000)	560 (81,200)	28.6	42 (31)	-	SS400	25

Typical Welding Parameters

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

SWAW

SAW

GM/AV

GTAW

FCAW

Non-FERROUS

APPENDIX