Superflux 787 X H-14

Type : Neutral

Conformances

AWS	A5.17/ ASME SFA5.17 F7A(P)8-EH14
JIS	Z3352 SA FB1
EN	ISO 14174-S A FB 1 / EN ISO 14171-A-S4
KR	4YM
ABS	3M, 4YM
LR	4YM
BV	A4YM
DNV·GL	IVYM
NK	KAW54M
CCS	4YM

Applications

- Offshore
- Pressure vessels
- Pipeline

Features

- Low hydrogen content
- Tandem, multi-electrode applicable
- Good impact value at low temperature after heat treatment
- Density : 1.2g/cm^3

Current

AC, DC +

Basicity Index

2.7

Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%		
	MgO + MnO	CaF_2 + CaO	Al_2O_3 + SiO_2
Superflux 787	35	35	30

Diameter / Packaging

Diameter	Spool	Basket		Coil						Pac				
mm (in)	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)				√	√									

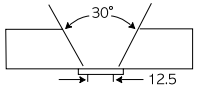
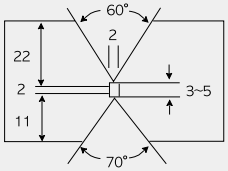
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.10	0.07	1.43	0.018	0.010	SS400	25
	0.06	0.13	1.37	0.016	0.007	SM490	39

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)	BM	Th.(mm)
H-14	470 (68,200)	560 (81,300)	26	-62 (-80)	130 (96)	SS400	25
	-	550 (76,800)	-	-40 (-40) -62 (-80)	80 (59) 50 (37)	SM490	39

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	4.0	39		1 2~7	500 600	28 32	35 30	1st
				Back Gouging				
				8 9~13	500 600	28 32	35 30	2nd