S-707 X L-8

Type : Active

Conformances

AWS	A5.17/ ASME SFA5.17 F7A4-EL8
JIS	Z3352 SA AB1
EN	ISO 14174-S A AB 1 / EN ISO 14171-A-S1
KR	3TM, 3YTM
ABS	3TM, 3YTM
LR	3TM, 3YTM
BV	A3TM, A3YTM
DNV·GL	IIIYTM
NK	KAW3TM, KAW53TM
RINA	3YM, 3YT
RS	3YTM

Applications

- Shipbuilding

Features

- Both side single-layer welding
- Low consumption of flux
- Density : 1.1g/cm^3

Current

AC, DC +

Basicity Index

1.6

Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%			
	$SiO_2 + TiO_2$	$CaO + MgO$	$Al_2O_3 + MnO$	CaF_2
S-707	15	30	40	15

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)								√	√					

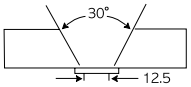
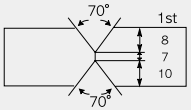
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
L-8	0.07	0.40	1.40	0.028	0.015	SS400	25
	0.08	0.32	1.29	0.015	0.014	AH36	25

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)
L-8	490 (71,000)	560 (81,000)	31	-40 (-40)	70 (52)	SS400	25
	-	570 (82,800)	-	-20 (-4)	40 (30)	AH36	25

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
L-8	4.0	25		1~13	570	30	40	AWS A5.17
L-8	4.8	25		1st 2nd	950 1100	34 37	40 30	Both side Single pass