

S-800WT X M-12K

Type : Neutral



Conformances

AWS A5.17/ ASME SFA5.17 F7A8-EM12K

JIS Z3352 SA FB1

EN ISO 14174-S A FB 1 / EN ISO 14171-A-S2Si

TÜV EN ISO 14174 - S A FB 1 / EN ISO 14171-A-S2Si

CWB CSA W48 F49A(P)6-EM12K

DB DIN EN ISO 14174-S A FB1

DIN EN ISO 14171-A-S2Si

CE

Applications

- Windtower
- Power plant

Features

- Good bead appearance
- Easy to remove slag
- Low consumption of flux
- Density : 1.1g/cm³

Current

AC, DC +

Basicity Index

2.7

Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%			
	SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaO + MgO	CaF ₂
S-800WT	10	30	40	15

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)				✓	✓			✓	✓	✓				

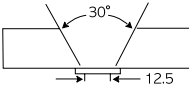
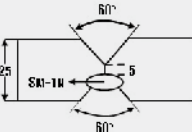
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Ti	B	BM	Th.(mm)
M-12K	0.090	0.20	1.45	0.020	0.010	0.008	0.0020	SM490	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Position of fracture	Temp °C(°F)	CVN-Impact Value J (ft.lbs)	BM	Th.(mm)
M-12K	520 (75,400)	570 (82,700)	32.0	-	-60 (-76)	130 (95)	SM490	25
	-	550 (79,800)		BM	-60 (-76)	100 (74)	S355NL	25

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
M-12K	4.0	25		1~13	570	30	40	AWS A5.17
M-12K	4.8	25		1	320	28	70	SM-1N
				1st	(L)750	28	60	Both Side
				2nd	(L)900	34	60	Single-pass
					(T)650	32	65	
					(T)650	38	65	(tandem)