

S-460Y X H-14

Type : Neutral



Conformances

AWS A5.23/ ASME SFA5.23 F8A8-EH14-G
 JIS Z3352 SA FB1
 EN ISO 14174-S A FB 1 / EN ISO 14171-A-S4
 KR 5Y46M H5
 ABS 5YQ460M H5, 5YQ500M H5, 4YQ500T
 LR 5Y46M H5
 BV A5Y46M HHH

DNV-GL VY46M (H5)
 NK KAW5Y46M H5,
 KAW63Y47M H5
 (-20°C ≥53J)
 CE

Applications

- Shipbuilding
- High strength steels (EH47)

Features

- Good impact value at low temperature and high tensile strength
- Single and multi electrode welding applicable
- Density : 1.2g/cm³

Current

AC, DC +

Basicity Index

2.5

Packages (Flux)

Tin Can 20kg(44lbs)
 PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%			
	SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
S-460Y	20	40	20	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)	✓			✓	✓			✓	✓					
6.4 (1/4)				✓	✓									

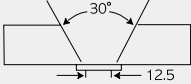
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM
H-14	0.10	0.28	1.50	0.020	0.005	SM570

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)
H-14	610 (88,500)	640 (92,800)	27.0	-60 (-76)	100 (74)	SM570	25

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 A5.23

SAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX