

# S-705EF X H-14

## Conformances

JIS Z3352 S A CG-I 1

EN ISO 14174-S A CG-I 1 / EN ISO 14171-A-S4

KR 2SMR, 2YSMR

2SR, 2YSR (Max. thick. 25mm)

ABS 2, 2Y

LR 2A, 2YA

BV A2M, A2YM

DNV-GL IIYM ( $t \leq 25\text{mm}$ )

NK KAW2SMP, KAW52SMP

KAW52SP

## Applications

- Shipbuilding (one-side welding)

## Features

- High deposition rate with high input use
- Suitable for one side welding of TMCP steel
- Density : 1.3g/cm<sup>3</sup>

## Current

AC, DC +

## Basicity Index

4.5

## Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

## Flux Composition

Consumable	Chemical Composition, wt%				
	SiO <sub>2</sub> + TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> + MnO	MgO + CaO	CaF <sub>2</sub>	FeO
S-705EF	15	10	35	10	30

## 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	Mo	BM	Th.(mm)
H-14	0.10	0.20	1.23	0.017	0.011	0.80	AH36	15
	0.10	0.21	1.29	0.014	0.010	0.90	AH36	20

**Typical Mechanical Properties of All-Weld Metal**

Wire	YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)	BM	Th.(mm)
H-14	430 (62,400)	560 (81,300)	23	0 (32)	60 (44)	AH36	15
	400 (58,000)	550 (79,800)	23	0 (32)	60 (44)	AH36	20

**Typical Welding Parameters**

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.8	15		1	900	35	22	
H-14	4.8	20		1	1000	36	20	