

S-705HF 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 3YSMR ($t \leq 25\text{mm}$)
 3YSR
 ABS 3Y
 LR 3YA

BV A3YM, A3YU
 DNV-GL IIIYM ($t \leq 25\text{mm}$)
 NK KAW53SMP ($t \leq 25\text{mm}$)
 KAW53SP ($t \leq 25\text{mm}$)

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^3

Current

AC, DC +

Basicity Index

4.2

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	MgO + CaO	CaF ₂	FeO
S-705HF	15	8	37	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)				✓	✓									

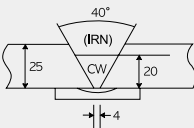
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Mo	Ti	B	BM	Th.(mm)
H-14	0.103	0.26	1.44	0.014	0.006	0.021	0.028	0.0045	EH36	25

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	509 (73,800)	618 (89,600)	22.6	-20 (-4)	80 (59)	EH36	25

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.8	25		1	1000	36	16	