S-737 X H-14

Type : Neutral

Conformances

AWS A5.17/ ASME SFA5.17 F7A(P)4-EH14
JIS Z3352 SA AB1
EN ISO 14174-S A AB 1 / EN ISO 14171-A-S4
KR 3M, 3YM
ABS 3M, 3YM
LR 3M, 3YM
DNV·GL IIIYM

Applications

- Storage tanks
- Pressure vessels
- Shipbuilding

Features

- Good performance and bead appearance
- Easy to remove slag
- 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

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)				√	√									

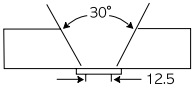
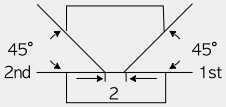
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.08	0.31	1.60	0.025	0.019	SS400	25
	0.07	0.40	1.53	0.020	0.013	SM490	28

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)
H-14	510 (74,000)	570 (82,800)	31	-40 (-40)	110 (81)	SS400	25
	-	540 (78,400)	-	-20 (-4)	60 (44)	SM490	28

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	AW A5.17
H-14	3.2	28		1 2~4 5 6~8	450 500 450 500	28 26 28 26	35 50 Horizontal ML 35 50	1st