

S-777MXT X A-2 [B-2]

Type : Neutral

Conformances

AWS A5.23/ ASME SFA5.23 F8PZ-EA2-A2
 AWS A5.23/ ASME SFA5.23 F8A(P)Z-EB2-B2
 JIS Z3352 SA AR1
 EN ISO 14174-S A AR 1 / EN ISO 14171-A-S2Mo [S2CrMo1]

Applications

- Heat resistant steels
- Fin-tube

Features

- Easy to remove slag
- High speed welding
- Density : 1.0g/cm³

Current

AC, DC +

Basicity Index

0.5

Packages (Flux)

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

Flux Composition

| Consumable | Chemical Composition, wt% | | |
|------------|---|------------------------|------------------------|
| | Al ₂ O ₃ + Fe ₂ O ₃ | TiO ₂ + MnO | SiO ₂ + CaO |
| S-777MXT | 55 | 25 | 15 |

Diameter / Packaging

- A-2 : √ • B-2 : ○

| 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) | | √ | | √○ | √○ | √ | √ | | √ | | √ | √○ | √ | √ |

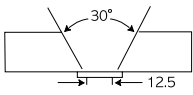
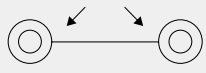
Typical Chemical Composition of All-Weld Metal(%)

| Wire | C | Si | Mn | P | S | Cr | Mo | BM | Th.(mm) |
|------|------|------|------|-------|-------|------|------|-----------|---------|
| A-2 | 0.05 | 0.68 | 0.75 | 0.020 | 0.010 | - | 0.46 | SM570 | 25 |
| B-2 | 0.05 | 0.68 | 0.75 | 0.020 | 0.010 | 1.06 | 0.44 | A387-Gr11 | 25 |

Typical Mechanical Properties of All-Weld Metal

| Wire | YS MPa(lbs/in ²) | TS MPa(lbs/in ²) | EL (%) | PWHT | Temp °C(°F) | CVN-Impact Value J (ft-lbs) | BM | Th.(mm) |
|------|---------------------------------|---------------------------------|-----------|-----------|----------------|--------------------------------|------------|---------|
| A-2 | 580 (84,100) | 640 (92,800) | 28.0 | As welded | - | - | SM570 | 25 |
| B-2 | 630 (91,400) | 720 (104,400) | 20.8 | As welded | 0 (32) | 32 (24) | A387-Gr.11 | 25 |
| B-2 | 560 (81,200) | 640 (92,800) | 25.0 | 690°CX1hr | 0 (32) | 45 (33) | A387-Gr.11 | 25 |

Typical Welding Parameters

| Wire | Dia. (mm) | Th. (mm) | Groove Design (mm) | Pass | Amp. (A) | Volt. (V) | Speed (cm/min) | Remarks |
|--------------|--------------|-------------|---|------|-------------|--------------|-------------------|-----------------------|
| A-2 (B-2) | 4.0 | 25 |  | 1-13 | 570 | 30 | 40 | AWS A5.23 |
| B-2 | 2.4 | 12 |  | 1 | 400 | 28 | 100 | Fin tube of boiler |

SWAW

SAW

GM/AW

GTAW

FCAW

Non-FERROUS

APPENDIX