

S-800MX X A-G [A-3]

Type : Neutral

Conformances

AWS A5.23/ ASME SFA5.23 F8A0-EG-G
 JIS Z3183 S502-H
 AWS A5.23/ ASME SFA5.23 F8AZ-EA3-G
 JIS Z3352 SA AR1
 EN ISO 14174-S A AR 1 / EN ISO 14171-A-S4 [S4Mo]

Applications

- Structural fabrication

Features

- Easy to remove slag
- Tandem welding applicable (H-beam)
- Density : 1.0g/cm³

Current

AC, DC +

Basicity Index

0.8

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
S-800MX	40	20	35

Diameter / Packaging

- A-G : ✓ • A-3 : ○

Diameter	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)				✓○	✓○			✓○						

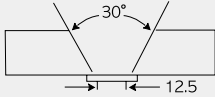
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Mo	BM
A-G	0.09	0.40	1.20	0.025	0.010	-	SM520B
A-3	0.08	0.35	1.15	0.020	0.010	0.45	SM570

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft-lbs)		BM	Th.(mm)
				0°C (32°F)	-18°C (0°F)		
A-G	590 (85,600)	630 (91,400)	27	-	120 (89)	SM520B	25
A-3	650 (94,300)	690 (100,000)	25	80 (59)	-	SM570	25

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-G (A-3)	4.0	25		1-13	570	30	40	AWS A5.23

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX