

Superflux 787 X H-14

Type : Neutral

Conformances

AWS A5.17/ ASME SFA5.17 F7A(P)8-EH14
JIS Z3352 SA FB1
EN ISO 14174-S A FB 1 / EN ISO 14171-A-S4
KR 4YM
ABS 3M, 4YM
LR 4YM

BV A4YM
DNV-GL IVYM
NK KAW54M
CCS 4YM

Applications

- Offshore
- Pressure vessels
- Pipeline

Features

- Low hydrogen content
- Tandem, multi-electrode applicable
- Good impact value at low temperature after heat treatment
- Density : 1.2g/cm³

Current

AC, DC +

Basicity Index

2.7

Packages (Flux)

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

Flux Composition

Consumable	Chemical Composition, wt%		
	MgO + MnO	CaF ₂ + CaO	Al ₂ O ₃ + SiO ₂
Superflux 787	35	35	30

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)				✓	✓									

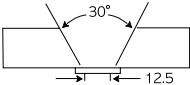
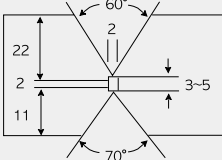
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.10	0.07	1.43	0.018	0.010	SS400	25
	0.06	0.13	1.37	0.016	0.007	SM490	39

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	470 (68,200)	560 (81,300)	26	-62 (-80)	130 (96)	SS400	25
	-	550 (76,800)	-	-40 (-40)	80 (59)	SM490	39
	-	-	-	-62 (-80)	50 (37)		

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	AWS A5.17
H-14	4.0	39		1 2~7	500 600	28 32	35 30	1st
				8 9~13	500 600	28 32	35 30	2nd

SWAW

SAW

GMWAW

GTAW

FCAW

Non-FERROUS

APPENDIX