

# S-777MX × H-14

TYPE : Neutral

AWS A5.17 / ASME SFA5.17 F7A(P)Z-EH14  
 JIS Z3183 S502-H  
 EN ISO 14174 S A AR 1 / EN ISO 14171 S4

SAW

## Applications

Single and multi-layer welding of miniature LPG tanks, spiral pipes, ships, agricultural implements, machinery, boilers, bridges and structural steels.

## Characteristics on Usage

Especially insensitive to oil, rust, scale, dirt and primers on the surface to be welded. Slag detachability in narrow groove and resistance to porosity are excellent. Suitable for welding of thin and medium plate in high speed welding. As the consumption of flux is low, it is very economical. Applicable to horizontal and flat fillet welding.

## Notes on Usage

- ① Dry the flux at 300~350°C(572~662°F) for 60 minutes before use.
- ② When the flux height is excessive, poor bead appearance may occur.
- ③ Remove rust, scales, oil, paint, water, dirt and slag of tack welds from the groove to obtain sound weld metal.
- ④ Use welding current and speed as low as possible at the first layer of groove to avoid cracking.

Approval	I Current	I Basicity Index
KR, ABS, LR, BV, DNV, GL, NK	AC, DC +	0.5

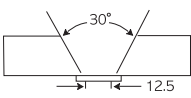
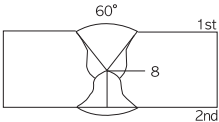
## Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.08	0.53	0.94	0.021	0.014	SS400	25

## Typical Mechanical Properties of All-Weld Metal

Wire	YS	TS	EL	Temp.	CVN-Impact Value	BM	Th.(mm)
	MPa(lbs/in <sup>2</sup> )	MPa(lbs/in <sup>2</sup> )	(%)	°C (°F)	J (ft · lbs)		
H-14	560 (81,000)	620 (90,000)	27	0 (32)	90 (66)	SS400	25
	-	530 (76,900)	-	-	-	SM490	20

## Typical Welding Conditions

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	4.8	20			800	36	25	Both Single pass
					850	37	45	