

S-717

Flux Properties

Class. JIS Z 3352 SA AB1
EN ISO 14174-S A AB 1

Current AC, DC +

Density 1.1g/cm³

BI 1.6

Grain Size 10 x 48 Mesh

Features

- Outstanding multi weldability for thick steel plates
- Pressure vessels, wind towers

Wire Approvals

Wire	Approvals	AWS	EN ISO 14174 / 14171
M-12K	ABS, BV, DNV, KR, LR, NK, RS, CWB, CE, DB, TUV	A5.17 F7A(P)6-EM12K	S A AB 1 / S42 4 AB S2Si
L-8		A5.17 F6A(P)4-EL8	S A AB 1 / S1
A-2		A5.23 F8A0(PZ)-EA2-A4	S A AB 1 / S2Mo

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

Wire	C	Si	Mn	P	S	Mo
M-12K	0.09	0.30	1.50	0.020	0.005	-
L-8	0.07	0.20	1.00	0.025	0.005	-
A-2	0.08	0.30	1.50	0.025	0.005	0.45

Typical Mechanical Properties of All-Weld Metal

Wire	Condition	YS	TS	EL	Temp °C (°F)	Impact ISO-V J (ft·lbs)
		MPa(ksi)	MPa(ksi)	(%)		
M-12K	DC+, As-welded	470(68)	550(80)	34	-50(-60)	80(59)
	DC+, 620°C×1hr	430(62)	540(78)	35	-50(-60)	80(59)
L-8	DC+, As-welded	430(62)	510(74)	36	-40(-40)	50(37)
	DC+, 620°C×1hr	410(59)	500(73)	37	-40(-40)	50(37)
A-2	DC+, As-welded	540(78)	650(94)	29	-20(0)	60(44)
	DC+, 620°C×1hr	530(77)	640(93)	30	-20(0)	60(44)

Wire Diameter & Packaging

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

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux