

# S-777Q

## Flux Properties

<b>Class.</b>	JIS Z 3352 SA AR1 EN ISO 14174-S A AR 1
<b>Current</b>	AC, DC +
<b>Density</b>	1.0g/cm <sup>3</sup>
<b>BI</b>	0.6
<b>Grain Size</b>	10 x 48 Mesh

## Features

- Outstanding weldability, good slag removal
- High speed welding

## Wire Approvals

Wire	Approvals	AWS	EN ISO 14174 / 14171
M-12K	LR, RINA, CE	A5.17 F7A2-EM12K	S A AR 1 / S2Si
H-14	LR, RINA, CE	A5.17 F7A2-EH14	S A AR 1 / S4
L-8		A5.17 F7A2-EL8	S A AR 1 / S1
L-12		A5.17 F7A2-EL12	S A AR 1 / S1
M-13K		A5.17 F7A2-EH13K	-

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

Wire	C	Si	Mn	P	S
M-12K	0.09	0.30	1.50	0.015	0.010
H-14	0.07	0.35	1.45	0.020	0.010
L-8	0.04	0.40	0.80	0.020	0.010
L-12	0.04	0.40	0.85	0.020	0.010
M-13K	0.06	0.80	0.80	0.010	0.020

## Typical Mechanical Properties of All-Weld Metal

Wire	Condition	YS MPa(ksi)	TS MPa(ksi)	EL (%)	Temp °C (°F)	Impact ISO-V J (ft·lbs)
M-12K	AC, As-welded	570(82)	630(91)	28	-30(-20)	90(66)
H-14	DC+, As-welded	510(74)	590(86)	30	-30(-20)	65(49)
L-8	AC, As-welded	440(64)	730(77)	30	0(32)	80(60)
L-12	AC, As-welded	470(68)	550(80)	31	0(32)	75(56)
M-13K	AC, As-welded	540(78)	620(90)	24	-20(0)	50(39)

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

### Wire Diameter & Packaging

Packaging
Tin Can 20kg (44lbs)

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux