

# SF-65xSW-H14

AWS A5.17 F7A2-EH14  
EN ISO 14171-A S 42 3 AB S4  
GB T5293 F5A3-H10Mn2

## SUBMERGED ARC WELDING WIRE AND FLUX FOR 490N/mm<sup>2</sup> HIGH TENSILE STEEL

### DESCRIPTION & APPLICATIONS :

- Suitable for thickness plates in deep groove applications. It is designed for multi-pass welds.
- Typical applications include pressure vessels, ship building, bridge and steel structures.

### NOTE ON USAGE :

- SF-65 is a neutral flux and need to be re-dry at 350°C for 1hr prior to use.
- Lower current is recommended for welding first pass.
- Appropriate new flux is required to add with the recycling used flux for maintain the welding quality.

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S
0.05	1.80	0.60	0.016	0.008

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )
500(51.0)	585(59.7)
EL %	IV -30°C/-40°C J(Kgf-m)
28	67(6.8)/48(4.9)

# SF-66xSW-M12K

AWS A5.17 F7A4/P4-EM12K  
EN ISO 14171-A S 42 5 FB S2Si  
GB T5293 F5A4/P4-H08MnA

## SUBMERGED ARC WELDING WIRE AND FLUX FOR 490N/mm<sup>2</sup> HIGH TENSILE STEEL

### DESCRIPTION & APPLICATIONS :

- Suitable for thickness plates in deep groove applications. It is designed for multi-pass welds.
- Typical applications include pressure vessels, ship building, bridge and steel structures.

### NOTE ON USAGE :

- SF-66 is a neutral flux and need to be re-dry at 350°C for 1hr prior to use.
- Lower current is recommended for welding first pass.
- Appropriate new flux is required to add with the recycling used flux for maintain the welding quality.

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S
0.07	1.51	0.42	0.018	0.015

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	EL %
460(46.9)	560(57.1)	30
425(43.4)	515(52.5)	29
IV -30°C/-50°C J(Kgf-m)	HEAT TREATMENT	
90(9.2)/70(7.1)	Welding process	
102(10.4)/80(8.2)	620°Cx1hr	