

SF-66xSW-60G

AWS A5.23 F8A8-EG-G
EN ISO 14171-A S 46 6 FB S3Si
GB -

SUBMERGED ARC WELDING WIRE AND FLUX FOR $\geq 550\text{N/mm}^2$ HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- It is suitable for single-layer as well as multi-layers submerged arc welding of extreme thick plates and high tensile strength low temperature thick plate.
- Suitable for the welding of shipbuilding, pressure vessels, steel structures and bridges.

NOTE ON USAGE :

- Rebake flux at 350°C for 1hours after opening.
- Use lower electric current during the welding of the bottom layer so as to avoid the crack.
- Appropriate new flux is required to add with the recycling used flux for maintaining the welding quality.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si
0.054	1.29	0.21
P	S	Mo
0.014	0.006	0.46

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)
535(54.6)	592(60.4)
ELONGATION RATE %	IMPACT VALUES -62 °C J(Kgf-m)
29	62(6.3)

SF-68xSW-60G

AWS A5.23 F8A2-EG-G
EN ISO 14171-A S 50 3 AB SZ
GB -

SUBMERGED ARC WELDING WIRE AND FLUX FOR $\geq 550\text{N/mm}^2$ HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- It is suitable for single-layer as well as multi-layers submerged arc welding of thick plates and extreme thick plate.
- It is used for the joint welding of 550N/mm² high tensile steel such as SM570, ocean construction and pressure vessel.

NOTE ON USAGE :

- Rebake flux at 350°C for 1hours after opening.
- Use lower electric current during the welding of the bottom layer so as to avoid the crack.
- Appropriate new flux is required to add with the recycling used flux for maintaining the welding quality.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si
0.05	2.00	0.60
P	S	Mo
0.021	0.008	0.15

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)
480(49.0)	580(59.1)
ELONGATION RATE %	IMPACT VALUES -62 °C J(Kgf-m)
29	60(6.1)