

Standards

TS EN ISO 14174	: SA AB 1 78 AC H5
EN ISO 14174	: SA AB 1 78AC H5
AWS A5.17	: F7A4-EM12
AWSA5.23	: F7A4-EA2-A2 / F8A4-EA4-A4

Basicity 1.7

Mechanical Properties

SAW Wire	AWS A5.17/ AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ($L_0=5d_0$) (%)	Impact Strength ISO-V(J)		
					0°C	-20°C	-40°C
S2	F7A4-EM 12	460	550	26	---	75	50
S2 Mo	F7A4 EA2-A2	510	640	25	---	---	60
S3 Mo	F8A4-EA4-A4	530	620	25	100	---	50

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn	Mo
S2	0.05	0.40	1.35	---
S2 Mo	0.06	0.40	1.40	0.50
S3 Mo	0.06	0.40	1.60	0.45

Features and Applications

- SAW flux type composed of agglomerated aluminate Basic.
- Basicity of the flux According to Boniszewski Formula is 1.7
- Excellent removal of slags of weld beads formed at high temperatures
- Suitability for use in both bilateral and tandem (AC/DC) welding operations.
- Sufficiently high toughness of weld metals obtained particularly by 2-pass welding operations.
- Suitability for use in welding of high-strength steels.
- Process requirement of re-drying at 300°C - 350°C for 2 hours.

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800019	25	Kraft Bag

Approvals: CE, GOST-R , SEPRO