S-705HF

Flux Properties

Class. JIS Z 3352 S A CG-I1
EN ISO 14174-S A CG-I 1
Current AC, DC +
Density 1.3g/cm^3
BI 4.2
Grain Size 20 x 80 Mesh

Features

- Outstanding weldability for one-sided welding
- Shipbuilding panel line

Wire Approvals

Wire	Approvals	EN ISO 14174 / 14171
H-14	ABS, BV, CCS, DNV, KR, LR, NK	S A CG-I 1 / S4

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

Wire	C	Si	Mn	P	S	Mo	B
H-14/CW/CBM-G22	0.10	0.26	1.44	0.014	0.005	0.13	0.005
H-14/IRN/BS-3W	0.10	0.30	1.25	0.015	0.004	0.07	0.005

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)
H-14/CW/CBM-G22	AC, Th.25mm(0.88in)	500(73)	600(87)	22	-20(0)	100(74)
H-14/IRN/BS-3W	AC, Th.25mm(0.88in)	510(74)	620(90)	22	-20(0)	80(59)

Wire Diameter & Packaging

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