

S-705LP

Flux Properties

- Class.** JIS Z 3352 S A CG-I1
EN ISO 14174 S A CG-I 1
- Current** AC, DC +
- Density** 1.2g/cm³
- BI** 2.7
- Grain Size** 10 x 48 Mesh

Features

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

Wire Approvals

Wire	Approvals	EN ISO 14174 / 14171
A-3	ABS, BV, 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	Ti	B
A-3/IRN-1/CB M-G22	0.06	0.28	1.40	0.017	0.002	0.25	0.02	0.004

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)
A-3/IRN-1/CBM- G22	AC, Th.16mm(0.62in)	520(75)	620(90)	24	-60(75)	75(55)

Wire Diameter & Packaging

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

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux