

S-777MXT

Flux Properties

- Class.** JIS Z 3352 SA AR1
EN ISO 14174-S A AR 1
- Current** AC, DC +
- Density** 1.0g/cm³
- BI** 0.5
- Grain Size** 10 x 48 Mesh

Features

- Outstanding weldability, good slag removal
- High speed welding

Wire Approvals

Wire	AWS	EN ISO 14174 / 14171
H-14	A5.17 F7A0- EH14	S A AR 1 / S4
M-12K	A5.17 F7A(P)Z-EM12K	S A AR 1 / S2Si
A-2	A5.23 F8PZ-EA2- A2	S A AR 1 / S2Mo
B-2	A5.23 F9AZ(F8PZ)-EB2-B2	S A AR 1
B-3	A5.23 F8PZ-EB3-B3	S A AR 1

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

Wire	C	Si	Mn	P	S	Cr	Mo
H-14	0.06	0.60	1.15	0.028	0.015	-	-
M-12K	0.06	0.50	0.70	0.025	0.015	-	-
A-2	0.05	0.65	0.75	0.020	0.010	-	0.45
B-2	0.06	0.60	0.55	0.022	0.015	1.25	0.40
B-3	0.07	0.55	0.50	0.018	0.010	2.05	0.95

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	AC, As-welded	530(76)	570(82)	32	-20(0)	40(30)
M-12K	AC, As-welded	510(74)	560(81)	28	0(32)	30(24)
	AC, 620°C×1hr	460(66)	540(78)	32	0(32)	60(44)
A-2	AC, 620°C×1hr	580(84)	640(92)	28	0(32)	45(33)
B-2	AC, As-welded	635(92)	722(104)	23	-	-
	AC, 690°C×1hr	560(81)	640(92)	25	0(32)	45(33)
B-3	AC, 690°C×1hr	570(82)	660(95)	20	0(32)	30(24)

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Wire Diameter & Packaging

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

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux