S-950S

Flux Properties

Class. JIS Z 3352 S A FB1
EN ISO 14174-S A FB 1 H5
Current AC, DC +
Density 1.2g/cm^3
BI 2.2
Grain Size 10 x 48 Mesh

Features

- Outstanding weldability, good slag removal
- Multi pole pipe welding

Wire Approvals

Wire	Approvals	AWS	EN ISO 14174 / 14171
M-12K	ABS	A5.17 F7A(P)8-EM12K	S A FB 1 H5 / S2Si
A-2	ABS	A5.23 F8A(P)5-EA2-A3, F8TA(P)8-EA2	S A FB 1 H5 / S2Mo
A-2TiB	ABS	A5.23 F8TA(P)8-EA2TiB	S A FB 1 H5 / S2MoTiB

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

Wire	C	Si	Mn	P	S	Mo
M-12K	0.06	0.20	1.50	0.020	0.005	-
A-2	0.06	0.20	1.50	0.015	0.001	0.43
A-2TiB	-	-	-	-	-	-

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)
M-12K	DC+, As-welded	460(67)	560(81)	34	-60(-75)	100(74)
	DC+, 620°C×1hr	440(64)	540(78)	33	-60(-75)	100(74)
A-2	DC+, As-welded	570(83)	640(93)	28	-46(-50)	80(60)
	DC+, 620°C×1hr	570(83)	640(93)	31	-46(-50)	70(52)
A-2TiB	DC+, As-welded	610(88)	690(100)	31	-60(-75)	100(74)
	DC+, 620°C×1hr	610(88)	690(100)	31	-60(-75)	80(59)

Wire Diameter & Packaging

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