

# Superflux600 x H-14[A-3]

TYPE : Neutral

AWS A5.17/ASME SFA5.17 F7A(P)6-EH14  
 JIS Z3183 S502-H  
 AWS A5.23/ASME SFA5.23 F8A(P)4-EA3-G  
 JIS Z3183 S584-H  
 EN ISO 14174 S A AB 1 / EN ISO 14171 S4[S4Mo]

## Applications

Superflux 600 x H-14 is multi-layer welding of various kinds of structure such as HSB500 and SM490 etc.

Superflux 600 x A-3 is multi-layer welding of various kinds of structure such as HSB600 and SM570 etc.

## Characteristics on Usage

It provides good bead appearance, better slag removal and together high impact value of the weld metal. It is relatively insensitive to rust and dirt on a base metal, and makes better resistance to pockmarks and pits. High impact values in both multi-run technique. As the consumption of flux is low, it is very economical.

## Notes on Usage

- ① Dry the flux at 300~350°C (572~662° F ) for 60 minutes before use.
- ② When the flux height is excessive, poor bead appearance may occur.
- ③ Use welding current and speed as low as possible at the first layer of groove to avoid cracking.

Approval	I Current	I Basicity Index
	AC, DC +	1.9

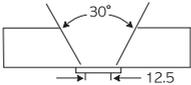
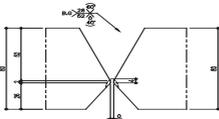
## Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
H-14	0.08	0.20	1.50	0.020	0.006	-	SS400	25
A-3	0.07	0.21	1.45	0.018	0.006	0.45	SM570	25
A-3	0.05	0.28	1.50	0.017	0.003	0.42	HSB600	80

## Typical Mechanical Properties of All-Weld Metal

Wire	YS	TS	EL	Position of fracture	CVN-Impact Value J (ft · lbs)			BM	Th. (mm)
	MPa(lbs/in <sup>2</sup> )	MPa(lbs/in <sup>2</sup> )	(%)		-20°C(-4° F)	-40°C(-40° F)	-51°C(-60° F)		
H-14	516 (74,800)	558 (80,900)	31	-	-	-	150 (111)	SS400	25
A-3	621 (90,100)	660 (95,700)	27	-	-	120 (89)	-	SM570	25
A-3	-	632 (91,700)	-	B.M.	100 (74)	-	-	HSB600	80

## Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14 (A-3)	4.0	25		1~13	570	30	40	AWS A5.17/ A5.23
A-3	4.8	80		1 2~18 19~26	500 550~650	28 28~32	40 18~40	Both Side Multi-pass