

S-705EF

Flux Properties

- Class.

JIS Z 3352 S A CG-I1

EN ISO 14174-S A CG-I 1
- Current

AC, DC +
- Density

1.3g/cm³
- 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, DNV, KR, LR, NK, RS	S A CG-I 1 / S4

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

Wire	C	Si	Mn	P	S	Mo	B
H-14/IRN/S-22	0.10	0.25	1.23	0.011	0.004	0.20	0.001
H-14/CW/CBM-G22	0.11	0.19	1.28	0.014	0.005	0.11	0.001

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/IRN/S-22	AC, Th.20mm(0.78in)	460(67)	560(81)	23	0(32)	60(44)
H-14/CW/CBM-G22	AC, Th.20mm(0.78in)	480(70)	580(84)	22	0(32)	55(33)

Wire Diameter & Packaging

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

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux