

# S-705HF

## Flux Properties

- Class.**
- JIS Z 3352 S A CG-I1  
EN ISO 14174-S A CG-I 1
- Current**
- AC, DC +
- Density**
- 1.3g/cm<sup>3</sup>
- 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, CCS, 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   | B     |
|-----------------|------|------|------|-------|-------|------|-------|
| H-14/CW/CBM-G22 | 0.10 | 0.26 | 1.44 | 0.014 | 0.005 | 0.13 | 0.005 |
| H-14/IRN/BS-3W  | 0.10 | 0.30 | 1.25 | 0.015 | 0.004 | 0.07 | 0.005 |

## Typical Mechanical Properties of All-Weld Metal

| Wire            | Condition       | YS<br>MPa(ksi) | TS<br>MPa(ksi) | EL<br>(%) | Temp<br>°C (°F) | Impact ISO-V<br>J (ft·lbs) |
|-----------------|-----------------|----------------|----------------|-----------|-----------------|----------------------------|
| H-14/CW/CBM-G22 | AC,             | 500(73)        | 600(87)        | 22        | -20(0)          | 100(74)                    |
|                 | Th.25mm(0.88in) |                |                |           |                 |                            |
| H-14/IRN/BS-3W  | AC,             | 510(74)        | 620(90)        | 22        | -20(0)          | 80(59)                     |
|                 | Th.25mm(0.88in) |                |                |           |                 |                            |

## Wire Diameter & Packaging

| Packaging                                   |
|---------------------------------------------|
| Tin Can 20kg (44lbs)<br>PE Bag 20kg (44lbs) |

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux