

S-777MX

Flux Properties

- Class.

JIS Z 3352 S A 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	Approvals	AWS	EN ISO 14174 / 14171
H-14	ABS, BV, DNV, KR, LR, NK, CE	A5.17 F7A0(PZ)-EH14	S A AR 1 / S4
A-G		A5.23 F8A0-EG-G	S A AR 1 / S4

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

Wire	C	Si	Mn	P	S
H-14	0.08	0.50	0.90	0.020	0.010
A-G	0.16	0.60	1.00	0.015	0.005

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	560(81)	620(90)	27	-20(0)	45(35)
	AC, 620°C×1hr	515(74)	620(90)	30	0(32)	110(81)
A-G	AC, As-welded	515(74)	610(88)	30	-20(0)	60(44)

Wire Diameter & Packaging

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

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux