

S-777MXH

Flux Properties

- Class.

JIS Z 3352 SA AB1

EN ISO 14174-S A AB 1
- Current

AC, DC +
- Density

1.2g/cm³
- BI

0.9
- Grain Size

10 x 48 Mesh

Features

- Outstanding weldability, good slag removal
- High speed welding
- Horizontal position welding

Wire Approvals

Wire	Approvals	AWS	EN ISO 14174 / 14171
H-14	ABS, BV, DNV, KR, LR, NK, CWB, CE	A5.17 F7A(P)2-EH14	S A AB 1 / S4
M-12K		A5.17 F7A(P)Z-EM12K	S A AB 1 / S2Si
A-3		A5.23 F8A4(P0)-EA3-A3	S A AB 1 / A S50 2 AB S4Mo

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

Wire	C	Si	Mn	P	S	Mo
H-14	0.08	0.30	1.25	0.020	0.005	-
M-12K	0.07	0.40	0.90	0.020	0.020	-
A-3	0.07	0.35	1.35	0.020	0.010	0.45

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	590(85)	610(88)	28	-30(-20)	80(60)
	AC, 620°C×1hr	540(78)	590(85)	30	-30(-20)	100(74)
M-12K	AC, As-welded	480(70)	570(83)	26	0(32)	80(60)
	AC, 620°C×1hr	450(65)	550(80)	30	0(32)	90(66)
A-3	AC, As-welded	650(94)	680(99)	25	-40(-40)	55(41)
	AC, 620°C×1hr	640(93)	665(97)	26	-20(0)	60(44)

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux

Wire Diameter & Packaging

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

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux