

S-BHF

Flux Properties

Class.	Flux
	JIS Z 3352 SA CS1
	EN ISO 14174-S A CS 1
	Wire
	JIS Z 3351 YS-S6 (H-14) / YS-M5 (A-3)
Current	Flux-Wire Combination
	JIS Z 3183 S502-H (S-BHF/H-14), / S582-H (S-BHF/A-3)
Density	AC, DC +
BI	1.1g/cm ³
Grain Size	1.6
	10 x 48 Mesh

Features

- Outstanding weldability for high heat input welding
- H-beam welding

Wire Approvals

Wire	AWS	EN ISO 14174 / 14171
H-14	A5.17 F7A0-EH14	S A CS 1 / S4
A-3	A5.23 F8AZ-EA3-A3	S A CS 1 / S4Mo

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

Wire	C	Si	Mn	P	S	Mo
H-14	0.05	0.60	1.30	0.012	0.006	-
A-3	0.05	0.60	1.30	0.009	0.003	0.48

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	DC+, As-welded	450(65)	560(80)	28	-20(0)	80(60)
A-3	DC+, As-welded	550(79)	640(92)	25	0(32)	70(53)

Wire Diameter & Packaging

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

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux