

SUPERFLUX 787

Flux Properties

- Class.

JIS Z 3352 SA FB1

EN ISO 14174-S A FB 1
- Current

AC, DC +
- Density

1.2g/cm³
- BI

2.7
- Grain Size

10 x 48 Mesh

Features

- Outstanding multi weldability for thick steel plates
- Pressure vessels, wind towers, pipes

Wire Approvals

Wire	Approvals	AWS	EN ISO 14174 / 14171
H-12K	ABS, DNV, CE	A5.17 F7A(P)8-EH12K	S A FB 1 / S 42 6 FB S3Si
A-3	ABS	A5.23 F8A6(P4)-EA3-A3	S A FB 1 / S4Mo
A-2TiB	ABS	A5.23 F8TA(P)8-EA2TiB	S A FB 1 / S2MoTiB
Ni-5	ABS, DNV, CE	A5.23 F8A(P)8-ENi5-Ni1	S A FB 1 / S 46 6 FB S3NiMo0.2
F-3		A5.23 F9A(P)8-EF3-F3	S A FB 1 / S3Ni1Mo
H-14	ABS, BV, CCS, DNV, KR, LR, NK, CE	A5.17 F7A(P)8-EH14	S A FB 1 / S4
M-12K	ABS	A5.17 F6A(P)6-EM12K	S A FB 1 / S2Si
M-14K	ABS	A5.17 F7A(P)8-EM14K	S A FB 1 / SU24
A-2	ABS	A5.23 F8A(P)6-EA2-A2	S A FB 1 / S2Mo
B-2	ABS	A5.23 F8P2-EB2-B2	S A FB 1 / SCrMo1

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

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

Wire	C	Si	Mn	P	S	Ni	Cr	Mo	Ti
H-12K	0.07	0.35	1.55	0.015	0.005	-	2.03	-	-
A-3	0.07	0.20	1.60	0.024	0.002	-	-	0.49	-
A-2TiB	-	-	-	-	-	-	-	-	-
Ni-5	0.06	0.35	1.40	0.015	0.003	0.83	0.05	0.25	-
F-3	0.07	0.35	1.70	0.020	0.003	0.85	-	0.50	-
H-14	0.07	0.26	1.65	0.018	0.003	-	-	-	-
M-12K	0.07	0.29	1.07	0.018	0.003	-	-	-	-
M-14K	0.06	0.65	1.25	0.013	0.003	-	-	-	0.02
A-2	0.08	0.25	1.14	0.020	0.002	-	-	0.41	-
B-2	0.09	0.35	0.99	0.022	0.007	-	-	0.50	-

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-12K	DC+, As-welded	490(71)	570(83)	32	-60(-75)	100(74)
	DC+, 620°C×1hr	450(65)	550(80)	33	-60(-75)	100(74)
A-3	DC+, As-welded	570(83)	640(93)	27	-50(-60)	50(37)
	DC+, 620°C×1hr	550(80)	630(91)	29	-40(-40)	50(37)
A-2TiB	DC+, As-welded	570(84)	650(95)	25	-60(-75)	70(52)
	DC+, 620°C×1hr	560(81)	640(93)	26	-60(-75)	60(44)
Ni-5	DC+, As-welded	590(86)	620(90)	31	-60(-75)	80(59)
	DC+, 620°C×1hr	540(78)	590(86)	33	-60(-75)	75(55)
F-3	DC+, As-welded	670(98)	730(106)	26	-60(-75)	100(73)
	DC+, 620°C×1hr	650(94)	720(104)	28	-60(-75)	70(52)
H-14	DC+, As-welded	510(74)	550(80)	30	-60(-75)	100(74)
	DC+, 620°C×1hr	460(67)	540(78)	34	-60(-75)	100(74)
M-12K	DC+, As-welded	440(65)	500(72)	36	-50(-60)	100(74)
	DC+, 620°C×1hr	400(57)	480(69)	37	-50(-60)	100(74)
M-14K	DC+, As-welded	520(75)	620(90)	30	-60(-75)	100(74)
	DC+, 620°C×1hr	500(73)	610(89)	31	-60(-75)	100(74)
A-2	DC+, As-welded	530(77)	610(88)	28	-50(-60)	80(60)
	DC+, 620°C×1hr	520(75)	610(88)	30	-50(-60)	80(68)
B-2	DC+, As-welded	530(77)	590(86)	27	-30(-20)	80(59)
	DC+, 620°C×1hr	590(86)	670(97)	25	0(32)	50(37)

Wire Diameter & Packaging

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

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux