

Superflux 600 X H-14 [A-3]

Type : Neutral

Conformances

AWS A5.17/ ASME SFA5.17 F7A(P)6-EH14
 JIS Z3183 S502-H
 AWS A5.23/ ASME SFA5.23 F8A(P)4-EA3-G
 JIS Z3352 SA FB1
 EN ISO 14174-S A AB 1 / EN ISO 14171-A-S4 [S4Mo]

Applications

- Structure fabrication (HSB500(SM490) and HSB600(SM570))

Features

- Good bead appearance
- Easy to remove slag
- Good resistance to pockmarks and pits
- Density : 1.2g/cm³

Current

AC, DC +

Basicity Index

1.9

Packages (Flux)

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

Flux Composition

Consumable	Chemical Composition, wt%			
	SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
Superflux 600	15	35	25	20

Diameter / Packaging

- H-14 : ✓ • A-3 : ○

Diameter	Spool		Basket		Coil					Pac				
	20kg (44lbs)	25kg (55lbs)	100kg (220lbs)	25kg (55lbs)	100kg (220lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	500kg (1102lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)	400kg (881lbs)
1.6 (1/16)	✓○			✓							✓		○	✓
2.0 (5/64)	✓○			✓○	✓	✓	✓					✓		
2.4 (3/32)	✓	✓		✓○	✓	✓								
3.2 (1/8)		✓		✓○	✓○	✓	✓	✓○			✓○	✓	✓	
4.0 (5/32)		✓		✓○	✓○	✓○		✓○	✓○	✓	✓○	✓	✓	✓
4.8 (3/16)	✓			✓○	✓○			✓○	✓					
6.4 (1/4)				✓	✓									

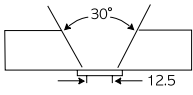
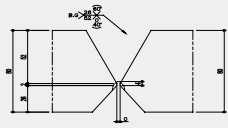
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
H-14	0.08	0.20	1.50	0.020	0.006	-	SS400	25
A-3	0.07	0.21	1.45	0.018	0.006	0.45	SM570	25
A-3	0.05	0.28	1.50	0.017	0.003	0.42	HSB600	80

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Position of fracture	CVN-Impact Value J (ft. lbs)			BM	Th. (mm)
					-20°C (-4°F)	-40°C (-40°F)	-51°C (-60°F)		
H-14	516 (74,800)	558 (80,900)	31	-	-	-	150 (111)	SS400	25
A-3	621 (90,100)	660 (95,700)	27	-	-	120 (89)	-	SM570	25
A-3	-	632 (91,700)	-	B.M.	100 (74)	-	-	HSB600	45

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14 (A-3)	4.0	25		1-13	570	30	40	AWS A5.17/ A5.23
A-3	4.8	80		1 2-18 19-26	500 550-650 500-650	28 28-32 28-32	40 18-40 20-40	Both Side Multi- pass

SWAW

SAW

GMWAW

GTAW

FCAW

Non-FERROUS

APPENDIX