

FOR HIGH TENSILE
STRENGTH STEEL

AWS F7A2-EH14
JIS S502-H
KS FS-FG2×YS-56

G-60×KD-50

Typical applications

Butt and fillet welding of ships, machines, vehicles, bridges and steel structures. Suitable for single or multi-layer welding of one side or both sides of steel plates in I groove, X groove, Y groove and U(V) groove.

Characteristics on Usage

- ① Insensitive to rust, scales, oil and dirt on the surface to be welded.
- ② Excellent resistance against herringbone and porosities.

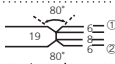
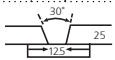
Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S	Base metal	
					Class	Thick (mm)
0.10	0.27	1.35	0.016	0.015	SM 400	20
0.08	0.45	1.85	0.014	0.013	SM 490	25

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m}		Base metal	
			-29°C	0°C	Class	Thick (mm)
380 {39}	480 {49}	31	40 {4}	60 {6}	SM 400	20
430 {44}	560 {57}	29	60 {6}	100 {10}	SM 490	25

Typical welding conditions

Thick (mm)	Wire dia. (mm)	Groove dimension (mm)	Amp.	Volt.	Welding method	Travel speed (cm/min)	Pass
20	4.8		800	34	General	40	①
			900	36		35	②
25	4.0		600	30	AWS A 5.17	40~50	1~14

Approved by