

SAW Wire / Flux

GA78×GS-8

AWS A5.17 F7A2-EL8 / A5.17M F49A3-EL8
JIS Z 3183 S502-H

Product Features:

- Submerged arc welding wires for mild steel and 490 N/mm² high tensile strength steel.
- Good porosity and crack resistance.
- Good bead appearance and easy slag removal.

Applications:

- Suitable for single or multiple pass(es) welding of mild and 50Kg/mm² high tensile strength steel structures on shipbuilding, machinery, bridges and general structures.

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

C	Si	Mn	P	S	Fe
0.04	0.19	1.14	0.024	0.011	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-30°C) J
432	485	32	41.5

Typical practice

Base material	Thickness mm	Welding process
A572	25	Groove weld with backing single electrode multiple-pass welding

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw