

# SAW Wire / Flux

## GA78 X GS-12K

AWS A5.17 F7A2-EM12K / A5.17M F49A3-EM12K  
JIS Z 3183 S502-H  
ISO 14171-A-S 42 3 AB SZ

### Product Features:

- Submerged arc welding wires for mild and 490 N/mm<sup>2</sup> high tensile strength steel.
- Good porosity resistance and crack resistance.
- High welding performance, easy slag removal, good bead appearance and less fume.

### Applications:

- Suitable for single or multiple pass(es) welding of mild and 50Kg/mm<sup>2</sup> 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
0.05	0.38	1.18	0.030	0.009	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-30°C) J
419	494	34	68

Typical practice

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

### Note:

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