

SAW Wire / Flux

GA86×GS-12K

AWS A5.17 F7A4-EM12K / A5.17M F49A4-EM12K
JIS Z 3183 S502-H
ISO 14171-A-S 42 4 CG S2Si

Product Features:

- Good impact toughness and crack resistance property.
- High welding performance, easy slag removal.

Applications:

- Suitable for single or multiple pass(es) welding of 490 N/mm² high tensile Strength steel structures on oil rig, shipbuilding, pressure vessels and general structures.

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

C	Si	Mn	P	S	Fe
0.05	0.21	1.40	0.033	0.012	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-40°C) J
448	519	35	76

Typical practice

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

Note:

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