

SAW Wire / Flux

GA60×GS80A3

AWS A5.23 F8A2-EG-G / A5.23M F55A3-EG-G
JIS Z 3183 S584-H
ISO 14171-A-S 50 3 CG S0

Product Features:

- Good porosity and crack resistance, Good bead appearance.
- High welding performance, easy slag removal.
- Suitable for multi-layer welding of tensile strength 570 N/mm² high tensile steel structure and bridge

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

C	Si	Mn	P	S	Mo
0.06	0.27	1.76	0.022	0.009	0.43

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-30°C) J	Impact value (-5°C) J
595	635	28	54	97

Typical practice

Base material	Plate thickness mm	Welding process	Single Groove	Welding Layer
SM570	32	Groove weld with backing single electrode multiple-pass welding	15°	22 passes / 11 layers

Note:

In case of flux package is damaged or the flux is not used immediately after unpacking, please dry the flux at 250~300 °C for 1 hour prior use.

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