

# SAW Wire / Flux

## GA68 × GS14

AWS A5.17 F7A8-EH14/A5.17M F49A6-EH14  
JIS Z 3183 S502-H  
ISO 14171-A-S 42 6 FB S4 H5

### Product Features:

- Suitable for welding of low temperature use of structure steels.
- Low temperature serving with good toughness till -60°C.
- Good porosity and crack resistance, Good bead appearance.
- High welding performance, easy slag removal.
- GA68 is Ca-Mg type agglomerated fluoride- basic flux ,with good low temperature impact toughness.

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

C	Si	Mn	P	S	Mo	Ni	Cr	Cu
0.12	0.02	1.90	0.013	0.006	0.01	0.01	0.03	0.02

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-60°C) J
490	557	31	118

Typical practice

Base material	Plate thickness mm	Welding process
A572	20	Groove weld with backing single electrode multiple-pass welding

### Note:

Please bake the flux at 250~300 °C for 1 hour prior use.

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