

# S-707T X H-14

Type : Neutral



## Conformances

AWS A5.17 / ASME SFA5.17 F7A(P)6-EH14  
 JIS Z3352 SA AB1  
 EN ISO 14174-S A AB 1 / EN ISO 14171-A-S4  
 KR 3T, 3YT, 4YM  
 ABS 4YM, 3T, 3YT  
 LR 4YM, 3T, 3YT

BV A4YM, A3T, A3YT  
 DNV-GL IVYM, IIIYT  
 NK KAW53T, KAW54M  
 CE  
 RINA 4YM, 3YT  
 RS 3T, 3YT, 4Y40T, 4Y40M H10

## Applications

- Shipbuilding

## Features

- Both side single-layer welding
- Low consumption of flux
- Density : 1.2g/cm<sup>3</sup>

## Current

AC, DC +

## Basicity Index

1.8

## Packages (Flux)

Tin Can 20kg(44lbs)  
 PE Bag 20kg(44lbs)

## Flux Composition

Consumable	Chemical Composition, wt%		
	SiO <sub>2</sub> + Al <sub>2</sub> O <sub>3</sub>	MgO + CaF <sub>2</sub> + CaO	MnO + FeO
S-707T	50	45	5

## Diameter / Packaging

Diameter mm (in)	Spool		Basket		Coil					Pac				
	20kg (44lbs)	25kg (55lbs)	100kg (220lbs)	25kg (55lbs)	100kg (220lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	500kg (1102lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)	400kg (881lbs)
1.6 (1/16)	✓			✓							✓			✓
2.0 (5/64)	✓			✓	✓	✓	✓					✓		
2.4 (3/32)	✓	✓		✓	✓	✓								
3.2 (1/8)		✓		✓	✓	✓	✓	✓			✓	✓	✓	
4.0 (5/32)		✓		✓	✓	✓		✓	✓	✓	✓	✓	✓	✓
4.8 (3/16)	✓			✓	✓			✓	✓					
6.4 (1/4)				✓	✓									

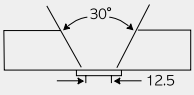
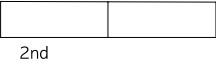
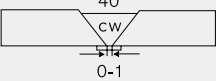
**Typical Chemical Composition of All-Weld Metal(%)**

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.10	0.37	1.54	0.020	0.012	SS400	25
	0.14	0.41	1.43	0.018	0.008	EH36	20
	0.11	0.29	1.52	0.018	0.009	DH36	25

**Typical Mechanical Properties of All-Weld Metal**

Wire	YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Position of fracture	CVN-Impact Value J (ft·lbs)			BM	Th.(mm)
					0°C (32°F)	-20°C (-4°F)	-51°C (-60°F)		
H-14	570 (82,800)	605 (87,900)	28.0	-	-	-	80 (59)	SS400	25
	-	570 (82,800)	-	BM	-	50 (37)	-	EH36	20
	-	580 (84,200)	23.0	-	70 (52)	-	-	DH36	25

**Typical Welding Parameters**

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.0	25		1-13	550	30	40	AWS A5.17
H-14	4.8	20		1st	L(DC+) 1100 T(AC) 700	37 42	100	Tandem
				2nd	L(DC+) 1200 T(AC) 700	37 42	100	SL
H-14	4.8	25		1	1150	35	20	FAB OSW (DC+)