

# Superflux 800T X M-12K [A-2]

Type : Neutral



## Conformances

AWS A5.17/ ASME SFA5.17 F7A8-EM12K  
 AWS A5.23/ ASME SFA5.23 F8A4-EA2-A3  
 JIS Z3352 SA FB1  
 EN ISO 14174-S A AB 1 / EN ISO 14171-A-S2Si [S2Mo]  
 TÜV EN ISO 14174 - S A FB 1 / EN ISO 14171-A - S2Si  
 EN 756 - S2 Mo

DB DIN EN ISO 14174-S A FB1  
 DIN EN ISO 14171-A-S2Si (M-12K)  
 DIN EN ISO 14171-A-S2Mo (A-2)  
 CE

## Applications

- Windtower
- Power plant

## Features

- Good bead appearance
- Easy to remove slag
- Low consumption of flux
- Density : 1.1g/cm<sup>3</sup>

## Current

AC, DC +

## Basicity Index

2.4

## Packages (Flux)

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

## Flux Composition

Consumable	Chemical Composition, wt%			
	SiO <sub>2</sub> + TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> + MnO	CaO + MgO	CaF <sub>2</sub>
Superflux 800T	10	30	40	15

## Diameter / Packaging

- M-12K : √    • A-2 : ○

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)				√	√			√	√	√	√			

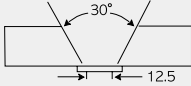
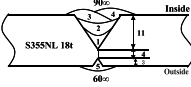
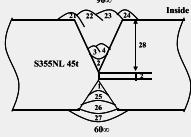
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Mo	BM	Th.(mm)
M-12K	0.09	0.35	1.40	0.023	0.006	-	SM490	25
A-2	0.09	0.24	1.48	0.020	0.006	0.43	SM570	25
M-12K	0.10	0.35	1.40	0.020	0.007	-	S355NL	45

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)
					-40°C (-40°F)	-50°C (-58°F)	-60°C (-76°F)		
M-12K	530 (76,700)	570 (82,700)	29	-	-	-	100 (74)	SM490	25
A-2	630 (91,400)	660 (95,700)	24	-	70 (52)	-	-	SM570	25
M-12K	-	550 (79,800)	-	BM	-	60 (44)	-	S355NL	45

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
M-12K (A-2)	4.0	25		1-13	570	30	40	AWS A5.17/ A5.23
M-12K	4.0	18		In 1 2-4 Out 5	550 600 650	28 32 34	40 40 40	Both Side Multi- pass
M-12K	4.0	45		In 1 2-24 Out 25 26-27	600-650 650 650	30-32 30 32	40-45 40 35	Both Side Multi- pass Sealing : SM-70(1.2mm)