

# S-777MX and H-14

TYPE: Neutral

AWS A5.17 / ASME SFA5.17 F7A(P)Z-EH14  
EN ISO 14174 SA AR 1 / EN ISO 14171 S4

## Applications

Single and multi-layer welding of miniature LPG tanks, spiral pipes, ships, agricultural implements, machinery, boilers, bridges and structural steels.

## Characteristics on Usage

Especially insensitive to oil, rust, scale, dirt and primers on the surface to be welded. Slag detachability in narrow groove and resistance to porosity are excellent. Suitable for thin and medium plate in high welding speed applications. Applicable to horizontal and flat fillet welding.

## Notes on Usage

- 1) Dry the flux at 300~350°C for 60 minutes before use.
- 2) When the flux height is excessive, poor bead appearance may occur.
- 3) Remove rust, scale, oil, paint, water, dirt and slag from tack welds from the groove to achieve optimum soundness of weld metal.
- 4) Use welding current and speed as low as possible at the first layer of groove to avoid cracking.

Approval	I Current	I Basicity Index
KR, ABS, LR, BV, DNV, GL, NK	AC, DC +	0.5

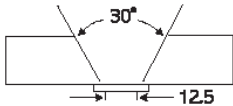
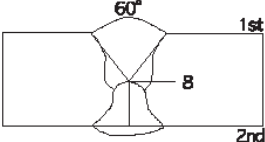
## Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
H-14	0.08	0.53	0.94	0.021	0.014	SS400	25

## Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa	TS MPa	EL (%)	Temp. °C	CVN-Impact Value J	BM	Th.(mm)
H-14	560	620	27	0	90	SS400	25

## Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
H-14	4.0	25		1~13	570	30	40	AWS A5.17
H-14	4.8	20			800 850	36 37	25 45	Both Single pass

Item	Pack	Part No.
777MX Flux	20kg can	HKS-777
2.4mm H14	25kg coil	HKH1424
3.2mm H14	25kg coil	HKH1432

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