

S-717 and M-12K

TYPE: Neutral

AWS A5.17 / ASME SFA5.17 F7A(P)6-EM12K
EN ISO 14174 S A AB 1 / EN ISO 14171 S2Si

Applications

Multi-layer welding of structural steels, offshore structures and thick, windmill, pressure vessels.

Characteristics on Usage

Good weldability for all range of thickness of plate. Weldmetal has excellent impact value and crack-resistance. Inactive type flux is not affected by welding parameter and is especially suitable for multi-layer welding of thick plate.

Notes on Usage

- 1) Dry the flux at 300~350°C for 60 minutes before use.
- 2) For the first layer in groove, keep the current and speed low in multi-layer welding applications.

Approval

KR, ABS, LR, BV, DNV, GL, NK, MRS
CWB, TÜV, CE-Mark, DB

I Current

AC, DC +

I Basicity Index

1.9

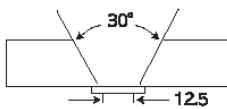
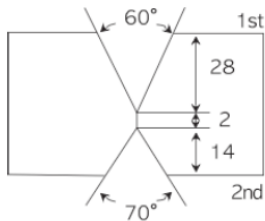
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	BM	Th.(mm)
M-12K	0.09	0.26	1.40	0.023	0.004	SS400	25
M-12K	0.08	0.54	1.47	0.025	0.018	BS4360-Gr,50D	44

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa	TS MPa	EL (%)	Temp. °C	CVN-Impact Value J	BM	Th.(mm)
M-12K	555	614	29	-51	60	SS400	25
M-12K	510	580	28	-20	70	BS4360-Gr,50D	44

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
M-12K	4.0	25		1~13	570	30	40	AWS A5.17
M-12K	4.0	44		2~14		600	36	} 1st Back Gouging ML } 40 } 50 2nd
				15		500	32	
				16~23		600	36	

Item	Pack	Part No.
717 Flux	20kg can	HKS-717
2.4mm M12K	25kg coil	HKM12K24
3.2mm M12K	25kg coil	HKM12K32

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com