

CA-502H × UC-36

For single and multi-layer welding of mild and 490N/mm² class high tensile strength steel

AWS F7A2-EH14
F7P2-EH14

Applications

CA-502H×UC-36 is well suited for super-high speed welding in plate of thin and medium thickness, as an example, miniature LPG tank of spiral pipe.

It is also applicable to fillet welding and butt welding in flat position of ships, machine, vehicles, pressure vessels, bridges and general steel structures.

Characteristics

- (1) It is comparatively insensitive to rust, scales, oil and primers on the surface to be welded.
- (2) As the consumption of flux is small, it is very economical.
- (3) Low temperature impact value is superior than CA-502.
- (4) Applicable to both AC and DC(+).

Notes on usage

- (1) Store the flux at the plate of moisture free and dry the flux at 250~350°C for about one hour before use.
- (2) Remove rust, scales, oil, paint, water, dirt and slag of tack welds from the groove in order to get sound welds.
- (3) When the flux height is excessive, poor bead appearance may occur.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Remarks	
					Base metal	PT(mm)
0.06	1.47	0.61	0.028	0.005	SM490A	25
0.08	1.32	0.45	0.015	0.010	EH36	20

Typical mechanical properties of weld metal

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J)		Remarks		
			-29°C	-40°C	Base metal	PT (mm)	PWHT
470	579	30	60	49	SM490A	25	As weld
-	580	31	50	-	EH36	20	As weld

• Approval : ABS, BV, DNV, GL, KR, LR, NK