

# CA-502H × UC-A3

For single and multi-layer welding of 550N/mm<sup>2</sup> class  
high tensile strength steel

AWS F8A0-EA3-G  
F8P0-EA3-G

## Applications

Butt and fillet welding of ships, pipes, miniature of LPG tanks and general 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) Applicable to both AC and DC(+).

## Notes on usage

- (1) Store the flux at the plate of moisture free and dry the flux 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	Mo	Remarks	
						Base metal	PT(mm)
0.05	1.43	0.65	0.021	0.018	0.52	SM570	25

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (MPa)	TS N/mm <sup>2</sup> (MPa)	EL (%)	IV (J)	Remarks		
			-18°C	Base metal	PT (mm)	PWHT
578	641	27	66	SM570	25	As Weld
-	570	-	43	SM520	20	As Weld