

CA-502 × UC-36

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

AWS F7A0-EH14
F7P0-EH14

Applications

CA-502×UC-36 is well suited for super-high speed welding in plate of thin and medium thickness, as an example, miniature LPG tank and 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) 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℃ 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)
0.08	1.17	0.83	0.021	0.012	SM490A	25
0.08	1.32	0.71	0.019	0.010	SM490A	20

Typical mechanical properties of weld metal

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J)		Remarks		
			0℃	-18℃	Base metal	PT (mm)	PWHT
470	559	30	55	37	SM490A	25	As weld
-	565	-	60	-	SM490A	20	As weld

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