

CA-50HR × UC-36

For one side welding of mild steel and 490N/mm²
class high tensile strength steel

KS B0531 S502-H
JIS Z3183 S502-H

Applications

CA-50HR x UC-36 are well suited for one side butt welding of ships, bridges and structural steels.

Characteristics

- (1) The deposition rate is high. It is very efficient.
- (2) Suitable of one side butt welding with iron powder.
- (3) Good mechanical properties with high heat input.
- (4) 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) The use of flux which has been re-used for welding in many times may cause deterioration of its usability. Therefore, the unused flux should be mixed properly with such used flux.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Ni	B	Base Metal
0.09	1.47	0.27	0.015	0.006	0.28	0.002	EH36(20t)
0.10	1.45	0.31	0.017	0.009	0.27	0.002	EH36(25t)

Typical mechanical properties of weld metal

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J)		Base Metal
			0°C	-20°C	
515	602	27	115	100	EH36(20t)
510	610	25	-	85	EH36(25t)

• Approval : ABS, BV, DNV, GL, KR, LR