

CA-526 × UC-12K

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

AWS F7A6-EM12K
F7P6-EM12K

Applications

Fillet and butt welding of steel structures, spiral pipe, ships, structures for ocean areas and thick pressure vessels.

Characteristics

- (1) Crack resistibility, pockmark and porosity resistibility are excellent.
- (2) Applicable to high current and good weldability for all range of thickness of plate.
- (3) Slag detachability and bead appearance are very good.
- (4) Suitable for multi-layer welding of thick plate.
- (5) Applicable to both AC and DC(+).

Notes on usage

- (1) Store the flux at the place of moisture free and dry the flux at 250~350°C for about one hour before use.
- (2) In case of multi-layer welding, use welding current and speed as low as possible at the first layer of groove to avoid cracking.
- (3) The use of the 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	Remarks	
					Base metal	PT(mm)
0.07	1.36	0.35	0.021	0.010	SM490A	25
0.08	1.40	0.32	0.019	0.011	EH36	34

Typical mechanical properties of weld metal

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J)		Remarks		
			0°C	-50°C	Base metal	PT (mm)	PWHT
472	561	31	90	47	SM490A	25	As weld
-	580	-	60	-	EH36	34	As weld

• Approval : ABS, BV, DNV, LR