AF-490E/US-29 FAMILIARC™

SAW flux and wire combination

Features:
- Suitable for single-pass-on-both-sides or multi-layer butt welding & fillet welding
- Good bead appearance and impact value

Classification: AWS A5.17 F7A2-EM12K, F6P4-EM12K
ISO 14174 S A AB 1

Type of flux: Sintered

Redrying of flux: 200~300℃x1h

Polarity: DCEP

Packaging data

Flux	Mesh	Bag			
AF-490E	12x65	20kg			
Volume mm		500W, 50H, 700L			
Wire	ϕ mm	Spool		Coil	
US-29	1.6	10kg	20kg	-	-
	2.0	10kg	20kg	25kg	-
	2.4	10kg	20kg	25kg	-
	3.2	-	-	25kg	-
	4.0	-	-	25kg	75kg
	4.8	-	-	25kg	75kg
Volume mm		240W, 110H, 240L	300W, 110H, 300L	430W, 90H, 430L	740W, 110H, 740L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.09	0.05~0.15
Si	0.22	0.10~0.35
Mn	1.04	0.80~1.25
P	0.012	0.030
S	0.006	0.030
Cu	0.11	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical		Guaranty	
0.2%YS (MPa)	410	350	400min.	330min.
TS (MPa)	500	460	483~655	410~550
El on 4d (%)	34	36	22min.	22min.
IV X ℃ (J)	-29℃:140	-40℃:150	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1

Composition (weld metal mass%)

	Typical
C	0.04
Si	0.29
Mn	1.28
P	0.024
S	0.005

Approvals

ABS	3Y
LR	3T, 3YM, 3YT
DNV	ⅢYTM
BV	3TM, 3YTM

Note: Single electrode