AF-490SP/US-36 FAMILIARC™

SAW flux and wire combination

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

Classification: AWS A5.17 F7A4-EH14, F7P4-EH14
ISO 14174 S A AR 1
Type of flux: Sintered
Redrying of flux: 200~300℃x1h
Polarity: DCEP

Packaging data

Flux	Mesh	Bag
AF-490SP	12x65	20kg
Volume mm		500W, 50H, 700L

Wire	ϕ mm	Spool		Coil			Drum
US-36	1.6	10kg	20kg	-	-	-	-
	2.0	10kg	20kg	-	-	-	-
	2.4	10kg	-	25kg	76kg	-	300kg
	3.2	-	-	25kg	76kg	-	300kg
	4.0	-	-	25kg	75kg	150kg	300kg
	4.8	-	-	25kg	75kg	150kg	-
	6.4	-	-	25kg	78kg	159kg	-
Volume mm		240W, 110H, 240L	300W, 110H, 300L	430W, 90H, 430L	740W, 110H, 740L	840W, 110H, 840L	680ϕ, 770H (2.4ϕ) 600ϕ, 920H (3.2, 4.0ϕ)

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.12	0.10~0.20
Si	0.03	0.10
Mn	1.95	1.70~2.20
P	0.013	0.030
S	0.005	0.030
Cu	0.11	0.35

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical
C	0.05
Si	0.35
Mn	1.19
P	0.022
S	0.004

Weld mechanical properties

	Typical		Guaranty	
0.2%YS (MPa)	500	480	400min.	400min.
TS (MPa)	570	570	483~655	483~655
El on 4d (%)	30	35	22min.	22min.
IV -40℃ (J)	150	110	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1