G-80/US-36 FAMILIARC™

SAW flux and wire combination

Features:
- Suitable for welding of medium or heavy thick plate
- Good Mechanical properties in multi-pass welding

Classification: AWS A5.17 F7A2-EH14, F6P2-EH14

Type of flux: Fused
Redrying Conditions: 150~350℃x1h
Polarity: AC

Packaging data

Flux	Mesh	Can
G-80	12x65	25kg
	12x200	25kg
	20x200	25kg
	32x200	25kg
	20xD	25kg
Volume mm		240W, 350H, 240L

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 (2.4ϕmm) 600ϕ, 920H (3.2, 4.0ϕmm)

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	0.09
Si	0.46
Mn	1.41
P	0.018
S	0.011

Weld mechanical properties

	Typical		Guaranty	
0.2%YS (MPa)	410	360	400min.	330min.
TS (MPa)	520	500	483~655	410~550
El on 4d (%)	29	35	22min.	22min.
IV -29℃ (J)	43	82	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1