PF-200/US-63S TRUSTARC™

Flux and wire combination for Mn-Mo and Mn-Mo-Ni steel

Features: ▪ Applied for ASTM A533 Type A, B, C, D Class 2 and equivalents

Classification: AWS A5.23 F10P2-EG-G

Type of flux: Bonded
Redrying of flux: 200~300℃x1h
Polarity: AC

Packaging data

Flux	Mesh	Can	
PF-200	48xD	20kg	
Volume mm		240W, 350H, 240L	
Wire	**ϕ mm**	**Coil**	
US-63S	3.2	25kg	-
	4.0	25kg	75kg
	4.8	25kg	75kg
Volume mm		430W, 90H, 430L	740W, 110H, 740L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.11	0.15
Si	0.14	0.40
Mn	1.70	1.30~2.20
P	0.006	0.020
S	0.004	0.020
Ni	1.47	1.00~1.75
Cr	0.16	0.40
Mo	0.47	0.30~0.80
Cu	0.08	0.30

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.08	0.16
Si	0.10	0.60
Mn	1.51	1.00~2.00
P	0.007	0.020
S	0.004	0.020
Ni	1.31	1.00~1.75
Mo	0.47	0.30~0.80
Cr	0.14	0.40

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	630	607min.
TS (MPa)	710	689~827
El on 4d (%)	24	16min.
IV (J)	-20℃:120	-29℃:27min.
PWHT (℃xh)	610x2	620±15x1