PF-500/US-521H TRUSTARC™

Flux and wire combination for 2.25%Cr-1%Mo-V steel

Features:
- Applied for ASTM A542 Type D Cl.4a and equivalents
- Excellent tensile strength at high temperatures and good creep rupture strength

Classification: AWS A5.23 F9P2-EG-G

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

Packaging data

Flux		Can		
PF-500	10x48	20kg		
Volume mm		240W, 350H, 240L		
Wire	**ϕ mm**	**Coil**		
US-521H	2.4	25kg	-	-
	3.2	25kg	-	-
	4.0	25kg	75kg	150kg
Volume mm		430W, 90H, 430L	740W, 110H, 740L	840W, 110H, 840L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.16	0.18
Si	0.21	0.30
Mn	1.19	0.30~1.50
P	0.002	0.010
S	0.001	0.010
Ni	<0.01	0.20
Cr	2.13	2.00~2.65
Mo	0.99	0.90~1.20
V	0.36	0.25~0.45
Nb	0.019	0.010~0.040
Cu	0.10	0.30

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.12	0.05~0.15
Si	0.15	0.05~0.35
Mn	1.14	0.50~1.30
P	0.003	0.010
S	0.001	0.010
Ni	<0.01	0.20
Cr	2.04	2.00~2.60
Mo	0.99	0.90~1.20
V	0.33	0.20~0.40
Nb	0.015	0.010~0.040
Cu	0.09	-

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	620	530min.
TS (MPa)	720	620min.
El on 4d (%)	23	16min.
IV -18℃ (J)	150	-
PWHT (℃xh)	705℃×8h	705±15x8