PF-H55AS/US-36J TRUSTARC™

Flux and wire combination

Features:
- Suitable for welding of structures for low temperature service
- Excellent impact value down to -60℃ and CTOD at temperatures down to -20℃

Classification: AWS A5.17 F7A8-EH14, F7P8-EH14

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

Packaging data

Flux	Mesh	Can	
PF-H55AS	10x48	20kg	
Volume mm		240W, 350H, 240L	
Wire	**ϕ mm**	**Coil**	
US-36J	3.2	25kg	76kg
	4.0	25kg	75kg
	4.8	25kg	75kg
Volume mm		430W, 90H, 430L	740W, 110H, 740L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.13	0.10~0.20
Si	0.01	0.10
Mn	2.00	1.70~2.20
P	0.007	0.030
S	0.008	0.030
Cu	0.10	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	485	430	400min.
TS (MPa)	555	530	483~655
El on 4d (%)	33	31	22min.
IV -62℃ (J)	170	180	27min.
PWHT (℃xh)	AW	620x1	AW & 620±15x1

Composition (weld metal mass%)

	Typical
C	0.07
Si	0.23
Mn	1.42
P	0.009
S	0.004
Ti	0.02
B	0.004

Approvals

	Single	Tandem
ABS	5Y400 H5	5Y400 H5
LR	5Y40M, H5	5Y40M, H5
DNV	ⅤY40M (H5), VL2-4L, VL4-4L	ⅤY40M (H5), VL2-4L, VL4-4L
BV	A5Y40M, H5	A5Y40M, H5
NK	KAWL3MH5	KAWL3M H10