TRUSTARC™ PF-H55LT/ FAMILIARC™ US-36

Flux and wire combination

Features:
- Suitable for welding of structures for low temperature service
- Excellent impact value down to -60℃ and CTOD down to -50℃

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

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

Packaging data

Flux	Mesh	Can		
PF-H55LT	10x48	20kg		
Volume mm		240W, 350H, 240L		
Wire	ϕ mm	Coil		
US-36	3.2	25kg	76kg	-
	4.0	25kg	75kg	150kg
	4.8	25kg	75kg	150kg
Volume mm		430W, 90H, 430L	740W, 110H, 740L	840W, 110H, 840L

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	0.008	0.030
Cu	0.12	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	490	460	400min.
TS (MPa)	555	540	483~655
El on 4d (%)	34	34	22min.
IV -62℃ (J)	180	160	27min.
PWHT (℃xh)	AW	620x1	AW & 620±15x1

Composition (weld metal mass%)

	Typical
C	0.08
Si	0.19
Mn	1.42
P	0.013
S	0.005
Ti	0.02
B	0.004

Approvals

	Single	Tandem
ABS	3M, 3YM, MG	4YM, MG
LR	5Y40M, H5	-
DNV	VYM, VL2-4, VL4-4	VYM
BV	A4YM, UP	-
NK	KAWL3M	KAWL3M