PF-H55S/US-2N 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 A5.23 F9A10-EG-Ni2, F9P8-EG-Ni2

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

Packaging data

Flux	Mesh	Can	
PF-H55S	10x48	20kg	
Volume mm		240W, 350H, 240L	
Wire	**ϕ mm**	**Coil**	
US-2N	3.2	25kg	-
	4.0	25kg	75kg
	4.8	25kg	-
Volume mm		430W, 90H, 430L	740W, 110H, 740L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.12	0.15
Si	0.01	0.10
Mn	1.70	1.50~1.90
P	0.007	0.015
S	0.004	0.015
Ni	2.60	2.40~2.80
Mo	0.25	0.20~0.30
Cu	0.10	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	610	590	538min.
TS (MPa)	675	645	621~758
El on 4d (%)	30	30	17min.
IV -62℃ (J)	140	120	27min.
PWHT (℃xh)	AW	620x2	AW & 620±15x2

Composition (weld metal mass%)

	Typical
C	0.06
Si	0.22
Mn	1.22
P	0.006
S	0.004
Ni	2.39
Mo	0.21
Cu	0.11

Approvals

LR	5Y50M H5
NK	KAW5Y50M H5

Note: Single electrode