PF-H62AS/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 temperature to -20℃

Classification: AWS A5.23 F9A8-EG-Ni2, F9P8-EG-Ni2

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

Packaging data

Flux	Mesh	Can	
PF-H62AS	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)	568	550	538min.
TS (MPa)	648	635	621~758
El on 4d (%)	29	30	17min.
IV -62℃ (J)	120	110	27min.
PWHT (℃xh)	AW	620x2	AW & 620±15x2

Composition (weld metal mass%)

	Typical
C	0.05
Si	0.25
Mn	1.30
P	0.011
S	0.005
Ni	2.46
Mo	0.24
Cu	0.10

Approvals

	Single	Tandem
ABS	5YQ500 H5	5YQ500 H5
LR	5Y50M H5	5Y50M H5
DNV	VY50M H5	VY50 H5
BV	A5Y50M H5	A5Y50M H5
NK	KAW5Y50M H5	KAW5Y50M H5
CCS	5Y50M H5	5Y50M H5