PF-H80AK/US-80LT TRUSTARC™

Flux and wire combination

Features:
- Suitable for welding of heavy duty structures
- Excellent impact value down to -80℃

Classification: AWS A5.23 F12A10-EG-G

Type of flux: Bonded
Redrying of flux: 250~350℃x1h
Polarity: AC

Packaging data

Flux	Mesh	Can	Wire	ϕ mm	Coil
PF-H80AK	10x48	20kg	**US-80LT**	3.2	25kg
				4.0	25kg
				4.8	25kg
Volume mm		240W, 350H, 240L	**Volume mm**		430W, 90H, 430L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.10	0.15
Si	0.11	0.25
Mn	2.03	1.75~2.25
P	0.007	0.015
S	0.004	0.015
Ni	2.59	2.40~2.90
Mo	0.74	0.60~0.90
Cu	0.12	0.40

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	760	745min.
TS (MPa)	840	828~965
El on 4d (%)	22	14min.
IV -73℃ (J)	90	27min.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.08	0.12
Si	0.28	0.80
Mn	1.65	1.20~2.20
P	0.009	0.030
S	0.004	0.030
Ni	2.45	2.10~2.90
Mo	0.74	0.50~1.00
Cu	0.12	0.35

Note: [a] Single values are maximum.

Approvals

	Single	Tandem
ABS	5YQ690, H5	5YQ690 H5
LR	5Y69M, H5	-
DNV	ⅤY69M	ⅤY69M H5
BV	A5Y69M H5	A5Y69M H5
NK	KAW5Y69M, H5	KAW5Y69M H5