PF-H80AS/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 F11A10-EG-G

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

Packaging data

Flux	Mesh	Can	Wire	ϕ mm	Coil
PF-H80AS	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)	740	676min.
TS (MPa)	860	759~896
El on 4d (%)	23	15min.
IV -73℃ (J)	83	27min.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.12
Si	0.51	0.80
Mn	1.64	1.20~2.20
P	0.011	0.030
S	0.002	0.030
Ni	2.42	2.10~2.90
Mo	0.73	0.50~1.00
Cu	0.11	0.35

Note: [a] Single values are maximum.

Approvals

ABS	4YQ690, MG
LR	4Y69M (H5)
DNV	ⅣY69M (H5), MG
BV	4Y69M H5, MG
CCS	4Y69M H5, MG
NK	KAW4Y69M, H5

Note: Single electrode