PF-H203/US-203E TRUSTARC™

Flux and wire combination

Features:
- Suitable for multi-layer butt welding of 3.5% Ni steel
- Excellent impact value down to -100℃ after PWHT

Classification: AWS A5.23 F7P15-ENi3-Ni3

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

Packaging data

Flux	Mesh	Can
PF-H203	10x48	20kg
Volume mm		240W, 350H, 240L
Wire	**ϕ mm**	**Coil**
US-203E	4.0	25kg
Volume mm		430W, 90H, 430L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.06	0.13
Si	0.18	0.05~0.30
Mn	0.98	0.60~1.20
P	0.005	0.020
S	0.002	0.020
Ni	3.48	3.10~3.80
Cr	0.03	0.15
Cu	0.11	0.35

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.04	0.12
Si	0.21	0.80
Mn	0.73	1.60
P	0.008	0.030
S	0.004	0.025
Ni	3.35	2.80~3.80
Cr	0.02	0.15
Cu	0.10	0.35

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	440	400min.
TS (MPa)	530	483~655
El on 4d (%)	34	22min.
IV -101℃ (J)	130	27min.
PWHT (℃xh)	610x1	620±15x1