

SF 134

Submerged Arc Welding Flux - Unalloyed & Low Alloyed Steels

Standards

EN ISO 14174	S A AB 1
TS EN ISO 14174	S A AB 1

Properties and Applications

Alumina-basic type, agglomerated submerged arc welding flux, which is designed for but and fillet welding and for the single-and multi-pass butt welding of mild, medium and high tensile steels in shipbuilding, pipe, pressure vessel and steel construction. Suitable to use in bridge, stadium, heavy steel construction and equipments. Provides high tensile strength in fine grained structural steels. Has a high current capacity and good characteristics both on alternative and direct current.

Typical Chemical Values of Weld Metal

Welding Wire	Type of Analysis	C	Si	Mn	Mo
SW 702	Weld Deposit	0.05	0.45	1.45	
SW 702 Mo	Weld Deposit	0.05	0.45	1.50	0.40
SW 702Si	Weld Deposit	0.05	0.60	1.60	
SW 703Si	Weld Deposit	0.07	0.55	1.90	

Typical Mechanical Values of Weld Metal

Test Condition	Welding Wire	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SW 702	440	530	30	-20°C → 100	-30°C → 90	-40°C → 50
As welded	SW 702 Mo	520	640	26	-20°C → 70	-30°C → 55	-40°C → 35
As welded	SW 702Si	470	560	29	-20°C → 90	-30°C → 70	-40°C → 50
As welded	SW 703Si	475	575	30	-30°C → 100	-40°C → 70	-50°C → 55

Wire-Flux Combinations Standards

Welding Wire	EN Designation of Wire	EN ISO/TS EN ISO 14171 - A	AWS Designation of Wire	AWS/ASME SFA 5.17/SFA 5.23
SW 702	S2	S 42 2 AB S2	EM12	F7A4-EM12
SW 702 Mo	S2Mo	S 46 3 AB S2Mo	EA2	F8A4-EA2
SW 702Si	S2Si	S 42 3 AB S2Si	EM12K	F7A4-EM12K
SW 703Si	S3Si	S 46 4 AB S3Si	EH12K	F7A5-EH12K

Application Information

Welding Positions

PA PB PC

Welding Parameters & Efficiency

Polarity:

Packaging Information

Product Code	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
401070AGM2	25 kg	25.60	1	25.60	Craft Bag

Storage & Re-Drying Information

Generally not required. If required, redry for 1 hour at 110°C.
During transportation and storage, it should be ensured that the packaging is not damaged or torn.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.