

S-777MXT X A-2 [B-2]

Type : Neutral

Conformances

AWS A5.23/ ASME SFA5.23 F8PZ-EA2-A2
 AWS A5.23/ ASME SFA5.23 F8A(P)Z-EB2-B2
 JIS Z3352 SA AR1
 EN ISO 14174-S A AR 1 / EN ISO 14171-A-S2Mo [S2CrMo1]

Applications

- Heat resistant steels
- Fin-tube

Features

- Easy to remove slag
- High speed welding
- Density : 1.0g/cm³

Current

AC, DC +

Basicity Index

0.5

Packages (Flux)

Tin Can 20kg(44lbs)
 PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%		
	Al ₂ O ₃ + Fe ₂ O ₃	TiO ₂ + MnO	SiO ₂ + CaO
S-777MXT	55	25	15

Diameter / Packaging

- A-2 : √ • B-2 : ○

Diameter mm (in)	Spool		Basket		Coil					Pac				
	20kg (44lbs)	25kg (55lbs)	100kg (220lbs)	25kg (55lbs)	100kg (220lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	500kg (1102lbs)	200kg (440lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)	400kg (881lbs)
1.6 (1/16)	√													
2.0 (5/64)		√		√○	○							√○	○	
2.4 (3/32)		√○		√○	○							○		
3.2 (1/8)		√		√○				√				○		
4.0 (5/32)		√		√○	√○	√	√		√		√	√○	√	√

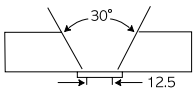
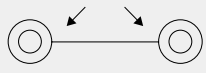
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	P	S	Cr	Mo	BM	Th.(mm)
A-2	0.05	0.68	0.75	0.020	0.010	-	0.46	SM570	25
B-2	0.05	0.68	0.75	0.020	0.010	1.06	0.44	A387-Gr11	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	PWHT	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	BM	Th.(mm)
A-2	580 (84,100)	640 (92,800)	28.0	As welded	-	-	SM570	25
B-2	630 (91,400)	720 (104,400)	20.8	As welded	0 (32)	32 (24)	A387-Gr.11	25
B-2	560 (81,200)	640 (92,800)	25.0	690°CX1hr	0 (32)	45 (33)	A387-Gr.11	25

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
A-2 (B-2)	4.0	25		1-13	570	30	40	AWS A5.23
B-2	2.4	12		1	400	28	100	Fin tube of boiler

SWAW

SAW

GM/AW

GTAW

FCAW

Non-FERROUS

APPENDIX