

PRODUCT DATA SHEET

Tri-Mark HPF-A72 Submerged Arc Flux

Tri-Mark HPF-A72 is an agglomerated flux with Mn and Si additions. HPF-A72 is a versatile flux with excellent weldability and easy slag removal; it is highly resistant to cracks and porosity and has a very good bead appearance. HPF-A72 is ideal for one-sided welding, double-sided welding, square edge joints, fillet welds and lap welds in structural and general engineering applications. It is recommended for welding inside grooves but is limited to material thicknesses below 25 mm. Due to the high oxidation potential, it does not require any special base metal preparation and cleaning prior to welding.

Applications

Tri-Mark HPF-A72 is used to weld gas bottles, truck wheels, structural shapes, pipes, joining plates, light boilermaking and parts with small diameters.

Storage and Re-baking

The higher the basicity index of agglomerated fluxes, the more hygroscopic such a flux would be. All agglomerated fluxes should therefore be stored in conditions of less than 70% relative humidity. Welding with damp flux can cause porosity. Re-drying of flux suspected of being moist should be done for approximately two hours at about 300°C at a flux depth of about 25 mm. For many applications, it is not necessary to re-dry the flux.

Classifications

AWS	A5.17/ASME SFA 5.17	F7A2-EM12K
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Typical Chemical Analysis (All weld metal)

% Carbon	0,05	% Phosphorous	0,018
% Manganese	1,5	% Sulphur	0,025
% Silicon	0,8		

Typical Mechanical Properties

Yield Strength	426 MPa
Tensile Strength	519 MPa
% Elongation	29
Charpy V-Notch at -29°C	23 J

Flux Characteristics

Maximum Welding Current	1 000 A
Polarity	DC or AC
Welding Speed	1 300 mm/min

Packing Data

Pack Mass (bags/kg)	Item Number
25,0	W071403

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