

Characteristics and Applications:

HOBART HN-528 is a basic agglomerated submerged-arc welding flux that is recommended for high productive welding procedures in unalloyed and fine-grained low alloy steels requiring good quality welds with high toughness properties at low temperatures. HN-528 is established for welding wind towers and providing a high level of consistency and mechanical property performance. The flux promotes a very stable arc which providing excellent slag detachment in narrow gap welds. The weld is of a uniform even profile with regular fine ripple formation and smooth toe blending. HN-528 is suitable for use with DC+ or AC and is ideal for single wire, twin wire, tandem arc.

Notes on Usage:

1. The flux must be re-dried at a temperature of 300~350°C for 2~4hr holding time when it is affected by moisture pick-up.
2. Re-circulation of flux should be limited to three cycles. After this, the flux should be mixed with twice its volume of new flux prior to further use.
3. We recommend using heated hoppers for storage of flux in production.

Typical Chemical Composition of Weld Metal (wt%)

Wire	Weld metal classification		C	Mn	Si	P	S
	AWS A5.17	EN ISO 14171-A					
HOBART M12K	F7A6-EM12K	S 38 5 FB S2Si	0.06	1.16	0.26	0.020	0.005
HOBART H12K	F7A8-EH12K	S 46 6 FB S3Si	0.08	1.51	0.33	0.024	0.007

Typical Mechanical Properties of Weld Metal

Wire	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C(°F)
HOBART M12K	448(65)	532(77)	33	186(137)	-51(-60)
HOBART H12K	498(72)	575(84)	28	152(112)	-51(-60)
				148(109)	-62(-80)

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