



# SAW FLUX

**CLASSIFICATION:** EN 14171 -A S2Si AWS A/SFA 5.20

JACKSUN EM12K ENISO14174SAAS187 DL Grade I

JACKSUN EH12K

F7A4/P4-EH12K

JACKSUN EL8

F7A2-EL8

## GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- Basic Flux having Basicity Index of 1.6
- For Carbon & Low Alloy Steels
- Suitable for Narrow Gap Welding
- Suitable for Single & Multi Wire twin and Tandem System
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding including "two-run" technique
- Suitable for Welding Speeds of 0.35-0.70 m/min
- Grain Size - 0.25-1.60 mm
- Type of Current - DCEP / AC
- Wall Neutrality Number with EM12K Wire is 23

## MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, Mpa	YS, Mpa	EL%	CVN Impact (J)
					0°C
JACKSUN EM12K	AW	530	410 - 490	25 - 27	47 - 53
JACKSUN EM12K	PW1	550 - 570	470 - 490	24 - 27	
JACKSUN EM12K	AW	550 - 570	470 - 490	25 - 27	47 - 53

## TYPICAL APPLICATIONS :

- General Structural Welding
- Long Seam and Cir Seam Welding of Pipes
- Fabrication of Pressure Vessel and Boiler
- Heavy Equipment Fabrication



## CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	S	P
AUTOMELT EM12K	0.07	1.35	0.75	0.025	0.030
AUTOMELT EH12K	0.08	1.55	0.45	0.025	0.030
AUTOMELT EL8	0.06	1.00	0.65	0.025	0.030

## CHEMICAL COMPOSITION OF FLUX:

SiO + TiO 2 2	CaO + MgO	Al O + MnO	CaF2
15	30	30	25

AW – As Welded; PW1 – After Post weld heat treatment of 620°C for 1 hour

PW2 – After Post Weld Heat treatment of 690°C for 1 hour

TW – Two Run

The chemistry and mechanical properties will depend on actual wire chemistry and arc voltage