

RAAJMELT-2

Alumina-Manganese-silicate type Agglomerated submerged arc welding Flux

CLASSIFICATION: - AWS: SFA/A 5.17

B.I. = 0.85

Grain Size = 8 X 60 BSS

F7A0-EL8

F7A2-EM12K

CHARACTERISTICS:-Raajmelt-2 is an agglomerated Si & Mn alloying submerged arc welding flux for the high speed welding of both butt and fillet welds in structural steel components. It is suitable for the single pass, double pass and multi pass welding of steel section up to 25mm thickness.

TYPICAL APPLICATION: - Raajmelt-2 suitable for all general application in low and medium tensile steels in combination with wire grade EL8 & EM12K. the flux is suitable for use with AC & DC current with single wire, twin wire and multi wire systems. Pressure vessels, boilers, LPG cylinder, pipes etc.

Drying requirement: - Redrying recommended at 250-300°C for one hour before use.

Main Constitutions (%)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂	S	P
25-35	10-20	30-50	10	≤0.07	≤0.07

All Weld Metal Chemical composition (Typical %)

UNDER Wires	C	Mn	Si	S	P
RAAJSAW-1	0.080	1.40	0.50	0.016	0.020
RAAJSAW-2	0.080	1.60	0.35	0.014	0.021

All Weld Metal Mechanical properties (Typical)

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	
				-20°C	-30°C
RAAJSAW-1	440	520	26	50 J	-----
RAAJSAW-2	480	550	24	80 J	50 J

Raajratna offer a wide range of submerged Arc welding Fluxes for SA welding.

PACKING SPECIFICATION: - packed in polythene-line paper bags of 25.00 kg net weight.

Customer packing on request.