

## RAAJMELT-4

### An agglomerated aluminates basic type submerged arc welding flux

**CLASSIFICATION:** - AWS: SFA/A 5.17

*F7 A4- F7 P4- EL8*

*F7 A5- F7 P5- EM12k*

**B.I. = 1.50**

**Grain Size = 8 X 60 BSS**

**CHARACTERISTICS:-** Raajmelt-4 is an agglomerated aluminates basic type submerged arc welding flux for very high current carrying on AC and DC. It is used with operational properties for single, double and multi wire system. It gives impact resistance sub zero and minus temperature. The flux can be used with EL8 and EM12K.

**TYPICAL APPLICATION:** - It is used for welding general structural steels, pressure vessels, pipe steels as well as fine Grain steels, Boiler Drums etc. suitable for fillet welding and single or multi pass butt welding with low, medium and high tensile steels. Single wire tandem and multi-wire welding is possible for increased productivity.

**Drying requirement:** - Redrying recommended at 350°C for two hour before use.

**Main Constitutions (%)**

SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>	S	P
15-20	25-30	15-20	20	≤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)(PWHT)**

UNDER Wires	YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	CHARPY "V" NOTCH IMPACT AT	
				-40°C	-46°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.



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