

RAAJMELT-81

An Agglomerated Aluminate Rutile-Silicate type submerged arc welding Flux for High Speed Welding

CLASSIFICATION: - AWS/SFA A5.17 F7AZ-EL8; F7A0-EM12K

CHARACTERISTICS: - RAAJMLET-81 is an agglomerated Aluminate Rutile-Silicate type Flux specially designed for butt and Fillet welding with high speed. Excellent slag removal and exceptional bead finish. It is preferably used for welding thin plates at speeds higher than up to 1800mm/min. .

B.I.: about 0.80

TYPICAL APPLICATION: Very much suitable for high travel speed welding such as spiral welding of pipes where weld shape, easy slag removal and surface finish are necessary. Best suitable for high speed beam welding process with twin wires auto system.

Drying requirement: - Re-drying recommended at 350°C for 2 hour before use.

Main Constitutions (%)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
30-40	10-20	30-50	10

All Weld Metal Chemical composition (Typical %)

UNDER Wires	C	Mn	Si	S	P
RAAJSAW-1	0.070	1.10	0.80	0.020	0.019
RAAJSAW-2	0.080	1.40	0.70	0.015	0.018

All Weld Metal Mechanical properties (Typical)

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	
				27°C	0°C
RAAJSAW-1	460	540	25	50 J	-----
RAAJSAW-2	450	570	24	60 J	40 J

Raajratna offer a wide range of submerged Arc welding Fluxes for different critical applications.

RAAJMELT-81 is almost equivalent to the LINCOLN 781, ESAB OK 10.81LS, AUTOMELT A81 fluxes

PACKING SPECIFICATION: - Packed in polythene-line paper bags of 25.00 kg net weight. Tailor made packing on request