

RAAJMELT-SS

General Purpose stainless steel submerged arc welding Flux

CLASSIFICATION: - DIN 32 522

B.I. = 1.10

Grain Size = 8 X 60 BSS

CHARACTERISTICS: - Raajmelt-SS is an special basic welding flux used for welding stainless steels and heat resistant steels in combination with the wire electrodes of AWS/SFA 5.9 in respect to the weld metal, That flux is neutral. This means that with the correct wires, low carbon steels can be welded. Flux has no chromium compensation, despite this there is very little loss of chromium. The metallurgical behavior in respect to silicon and manganese is neutral.

TYPICAL APPLICATION: - Raajmelt-SS For joint welding on high alloy Cr-Ni steels type: AISI 304, 304L, 316, 316L, 347, 321, 318, 410, 430 etc.

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

Main Constitutions (%)

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

All Weld Metal Chemical composition (%)

UNDER Wires	C	Mn	Si	Cr	Ni	Mo	Cb
RAAJSAWER308L	<.03	< 1.50	<0.90	>19.50	>9.00	--	--
RAAJSAWER309L	<.03	< 1.50	<0.90	>22.00	>11.00	--	--
RAAJSAWER316L	<.03	< 1.50	<0.90	>18.50	>12.00	>2.00	--
RAAJSAWER347	<.07	< 1.50	<0.90	>19.50	>9.00	--	>8XC
RAAJSAWER430	<.07	< 0.75	<0.90	>11.50	---	--	--

All Weld Metal Mechanical properties (Typical)

UNDER Wires	UTS (N/mm ²)	0.2% proof (N/mm ²)	1.0% proof (N/mm ²)	EL %	IMPACT at +20°C J
RAAJSAWER308L	>500	>320	>350	>35	>75
RAAJSAWER309L	>550	>350	>370	>35	>75
RAAJSAWER316L	>520	>350	>370	>35	>75
RAAJSAWER347	>520	>320	>370	>30	>75
RAAJSAWER430	>800	>320	>350	>20	>50

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.