

RAAJMELT-1

Alumina-Silicate type Agglomerated submerged arc welding Flux

CLASSIFICATION: - AWS: SFA/A 5.17

B.I. = 0.80

Grain Size = 8 X 60 BSS

F7A0-EL8

F7A2-EM12K

CHARACTERISTICS:- Raajmelt-1 is saw flux for welding mild steel and medium tensile steels to get x-ray quality welds. Good mechanical properties with smooth and shiny weld bead. Auto removable slag even in the case of the root runs.

TYPICAL APPLICATION: - structural's, offshore platforms, ships , pressure vessels and boilers involving steels. Machine building, automobiles, locomotives, earthmoving equipment, LPG cylinder, penstocks 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
30-40	10-20	30-50	10	≤0.07	≤0.07

All Weld Metal Chemical composition (Typical %)

UNDER Wires	C	Mn	Si	S	P
RAAJSAW-1	0.085	1.10	0.55	0.016	0.020
RAAJSAW-2	0.095	1.20	0.45	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	
				0°C	-20°C
RAAJSAW-1	450	530	28	60 J	-----
RAAJSAW-2	460	555	26	80 J	60 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.