

RAAJMELT-Spl

Alumina-basic type Agglomerated submerged arc welding Flux

CLASSIFICATION: - AWS/SFA 5.17 & 5.23

F6A2-F6P2-EL8
F7A2-F6P2-EM12K
F8A4-F7P2-EH14
F7A2-EA2

B.I. = 1.50

Grain Size = 8 X 60 BSS

CHARACTERISTICS: - Raajmelt-spl 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, EM12K, EH14 and EA2.

TYPICAL APPLICATION: - Raajmelt-spl 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 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 |
|------------------------------------|---------|-------------------------------------|------------------|-------|-------|
| 5-15 | 20-30 | 10-20 | 30 | ≤0.07 | ≤0.07 |

All Weld Metal Chemical composition (Typical %)

| Wire | C | Mn | Si | S | P |
|------------|------|------|------|-------|-------|
| RAAJSAW-1 | 0.08 | 1.20 | 0.50 | 0.016 | 0.020 |
| RAAJSAW-2 | 0.08 | 1.30 | 0.40 | 0.015 | 0.018 |
| RAAJSAW-3 | 0.10 | 1.60 | 0.50 | 0.015 | 0.022 |
| RAAJSAW-A2 | 0.07 | 1.15 | 0.25 | 0.018 | 0.022 |

All Weld Metal Mechanical properties (Typical)

| UNDER Wires | YS (N/mm ²) | UTS (N/mm ²) | EL % | CHARPY "V" NOTCH IMPACT AT Joules °C | |
|-------------|----------------------------|-----------------------------|------|--|-----|
| RAAJSAW-1 | 440 | 520 | 26 | 45 | 0 |
| RAAJSAW-2 | 480 | 550 | 26 | 50 | -20 |
| RAAJSAW-3 | 500 | 580 | 22 | 40 | -20 |
| RAAJSAW-A2 | 520 | 610 | 22 | 40 | -20 |

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.