

RAAJMELT-3

Basic-Aluminates type Agglomerated submerged arc welding Flux

CLASSIFICATION: - AWS: SFA/A 5.17 F7A2-EH14

CHARACTERISTICS: - RAAJMELT-3 is an agglomerated basic-aluminates flux for having a very high current carrying capacity in both AC & DC. The weld gives good sub-zero impact properties and extreme resistance to cracking. The behavior in terms of Mn is neutral while slight Si pickup occurs. Hence use of high Mn wires (like EH14) is recommended

TYPICAL APPLICATION: - Raajmelt-3 suitable for single and multipass welding. Welding of structure's, pressure vassals, boilers and others fabrications involving medium tensile, carbon and low alloys steels.

Drying requirement: - Re-drying 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
10-20	20-40	20-40	20	≤0.07	≤0.07

All Weld Metal Chemical composition (%)

Under Wire	C	Mn	Si	S	P
RAAJSAW-3	0.15 Max.	1.30-1.75	0.40 Max.	0.040 Max.	0.040 Max.

All Weld Metal Mechanical properties

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	
				-20°C	-30°C
RAAJSAW-3	400-480	480-650	22-28	60 J	40 J

Grain size: Std. or as per customer's requirement.

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.