STRONG FLUX - 16HS

FLUX FOR SUBMERGED ARC WELDING

CLASSIFICATION: AWS SFA 5.17 F7A2-EM12K, F7A2-EH14

CHARACTERISTICS

STRONG FLUX 16HS is an agglomerated acid type flux mainly for High Speed Tandem welding of C-Mn Steels and low alloy structural steels. This flux is suitable for very high speed welding and provides very good weld bead appearance and excellent slag removal even with narrow groove and fillet welds. This flux is also highly resistant to cracking and porosity and is insensitive to oil, rust, scale and dirt on the surface to be welded.

APPLICATIONS

General structural steels specially H beam welding for PEB, Girder, Pipes steels, Penstock shells, Earthmoving equipment, High mast poles, etc.

CURRENT CARRYING CAPACITY

This flux exhibits stable operating characteristics up-to 900 amps. Flux is suitable for use with both AC and DC for single wire, Twin wire and tandem wire (AC/DC).

FLUX TYPE - Alumina - Rutile

BASICITY INDEX - 0.70 (Boniszewski)

GRAIN SIZE - 10-60 MESHES

COMPOSITION OF THE FLUX (%)

CaO + MgO	SiO2 + TiO2	Al2O3 + MnO	CaF2	S	P
8.0-12.0	20.0-30.0	50.0-60.0	5.0-10.0	0.035 MAX	0.040 MAX

ALL WELD MECHANICAL PROPERTIES

SAW WIRE	C	Mn	Si	S	P	Cu	Y.S.	U.T.S.	ELONGATION (L=4D)	CHARPY V NOTCH IMPACT
	%						MPa	MPa	%	-20°C
EM12K	0.05	1.00	0.40	0.030	0.030	0.30	425	540	>22	>30
EH14	0.10	1.80	0.40	0.030	0.030	0.30	530	550	>22	>60

WELDING PARAMETERS - Current up-to 900 amps, Voltage: 28-38 V, Speed: Up-to 5.00 mts/min.

PACKAGING SPECIFICATION - In 25 kg Paper / PP Bag with Plastic liner.

RE-DRYING CONDITION - Recommended at 300° - 350°C for 2 hours.

STRONGWIRE Industries

www.strongwire.in