

STRONG FLUX - 10G

FLUX FOR SUBMERGED ARC WELDING

CLASSIFICATION: AWS SFA 5.17 F7AZ-EL8, F7A4-EM12K, F7A4-EH14



CHARACTERISTICS

STRONG FLUX 10G is an agglomerated fluoride basic type flux mainly for welding of General Structural Steels and Pressure vessel steels. The behavior in terms of Mn is neutral while slight Si pick-up occurs hence use with medium & high Mn wires is recommended. This flux offers good slag detachability along with uniform and smooth weld bead finish. The flux has low moisture pick-up tendency, hence weld metal diffusible hydrogen is low.

APPLICATIONS

Fine Grain Steels, General Structural Steels, API grades pipes, Penstock shells, Pressure vessels and boilers involving Medium and High strength Steels.

CURRENT CARRYING CAPACITY

This flux exhibits stable operating characteristics up-to 1000 amps. Flux is suitable for use with both AC and DC for single wire, Twin wire and tandem wire (AC/DC).

FLUX TYPE - Fluoride Basic

BASICITY INDEX - 1.8 (Boniszewski)

GRAIN SIZE - 15-35 MESHES

COMPOSITION OF THE FLUX (%)

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	S	P
18.0-25.0	28.0-35.0	23.0-30.0	16.0-25.0	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	%	-18°C	-40°C
EL8	0.05	0.55	0.15	0.025	0.025	0.25	350	440	>29	>75	-
EM12K	0.07	1.20	0.40	0.025	0.025	0.30	430	545	>30	>60	>40
EH14	0.08	1.50	0.25	0.025	0.025	0.30	445	560	>28	>60	>50

WELDING PARAMETERS - Current up-to 1000 amps, Voltage: 24-34 V, Speed: Up-to 1.00 mts/min.

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

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