

STRONG FLUX - 62

FLUX FOR SUBMERGED ARC WELDING

CLASSIFICATION: AWS SFA 5.23 F7A8/F7P8-EH12K,
F7A6/F7P6-EH10K, F7A6/P6-EH14, F8A3-EA2, F8A3-EA3



CHARACTERISTICS

STRONG FLUX 62 is an all-mineral non-alloying flux where the weld metal can be carefully controlled independently of the welding parameters through suitable choice of wire. This flux is designed for multi-pass welding of high tensile steel as well as low alloyed steel.

It allows for high current carrying capacity in both AC & DC and is especially suitable for narrow gap welding due to its excellent slag detachability.

APPLICATIONS

Suitable for hard facing applications on Plates & Rollers, Fine Grain Steels, General Structural Steels, API grades pipes, Penstock shells, Pressure vessels and Boilers.

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 - 3.5 (Boniszewski)

GRAIN SIZE - 10-50 MESHES

COMPOSITION OF THE FLUX (%)

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	S	P
10.0-15.0	25.0-35.0	30.0-40.0	15.0-20.0	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	%	-40°C	-50°C
EH10K	0.08	1.30	0.20	0.020	0.020	0.25	410	520	>27	>50	>70
EH12K	0.10	1.20	0.30	0.020	0.020	0.25	460	560	>26	>50	>80
EH14	0.08	1.60	0.25	0.020	0.025	0.25	450	550	>27	>40	>60

WELDING PARAMETERS - Current up-to 1200 amps, Voltage: 24-34 V,
Speed: Up-to 0.50 mts/min.

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

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