

STRONG FLUX - 12HS-MOD

Modified High-Speed Aluminium-Rutile SAW Flux for Thin Plate Welding

CLASSIFICATION: AWS SFA 5.17 F6A0-EL8, F7A2-EM12K, F7A2-EH10K, F7A2-EH14, AWS SFA 5.23 F8A0-EA2



CHARACTERISTICS

STRONG FLUX 12HS-MOD is a modified acidic Aluminium-Rutile SAW flux designed for welding thin base plates (5 mm or less). It has a finer grain size (18-60 mesh), making it ideal for 1.60 mm and 2.00 mm Carbon-Manganese steel wires. It ensures excellent arc stability, low flux consumption, resistance to cracking & porosity, and good tolerance to surface contamination.

APPLICATIONS

High mast pole manufacturing, Light pole fabrication, Thin structural steel fabrication, Tubular pole welding, Sheet metal structural fabrication, Automated pole production lines.

FLUX TYPE - Alumina - Rutile

BASICITY INDEX - 0.80 (Boniszewski)

GRAIN SIZE - 18-60 MESHES

COMPOSITION OF THE FLUX (%)

SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaF ₂	S	P
25-35	50-60	3-10	0.035 MAX	0.040 MAX

ALL WELD MECHANICAL PROPERTIES

SAW WIRE	C	Mn	Si	S	P	Cu	Mo	Y.S.	U.T.S.	ELONGATION (L=4D)		CVN IMPACT	
										MPa	MPa	%	0°C
EL8	0.08	0.70	0.50	0.030	0.030	0.30	-	340	470	25	32	-	
EM12K	0.10	1.20	0.45	0.030	0.030	0.30	-	420	545	26	55	32	
EH10K	0.10	1.45	0.45	0.030	0.030	0.30	-	460	600	25	60	35	
EH14	0.10	1.65	0.55	0.030	0.030	0.30	-	480	625	25	70	38	
EA2	0.10	1.15	0.50	0.030	0.030	0.30	0.50	500	630	24	40	-	

WELDING PARAMETERS - Current up-to 800 amps, Voltage: 24-34 V, Speed: Up-to 1.50 mts/min.

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

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