

# STRONG FLUX - MP2

## Multi-Purpose Basic SAW Flux

**CLASSIFICATION: AWS SFA 5.17 F6A2-EL8, F7A2-EM12K, F7A2-EH10K, F7A2-EH14, AWS SFA 5.23 F8A2-EA2**



### CHARACTERISTICS

STRONG FLUX MP2 is a fluoride-basic agglomerated SAW flux engineered for multi-purpose welding applications requiring reliable mechanical properties and process flexibility. Designed to offer excellent arc stability, superior slag detachability, and consistent weld metal quality, making it suitable for a wide range of wire grades and diameters.

### APPLICATIONS

Structural steel fabrication, Heavy girders and beams, Pipe welding and pipelines, Pre-Engineered Buildings (PEB), Boilers and pressure vessel components, General and heavy engineering fabrication

### FLUX TYPE - Fluoride Basic

### BASICITY INDEX - 1.6 (Boniszewski)

### GRAIN SIZE - 10-60 MESHES

### COMPOSITION OF THE FLUX (%)

SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	S	P
15-25	25-35	20-30	15-25	0.035 MAX	0.040 MAX

### TYPICAL ALL WELD MECHANICAL PROPERTIES

SAW WIRE	C	Mn	Si	S	P	Cu	Mo	Y.S.	U.T.S.	ELONGATION (L=4D)	CHARPY V NOTCH IMPACT		
											MPa	MPa	%
EL8	0.08	0.65	0.20	0.025	0.025	0.25	-	350	460	26	60	35	-
EM12 K	0.08	1.20	0.30	0.025	0.025	0.25	-	430	550	27	95	60	-
EH10K	0.10	1.40	0.25	0.025	0.025	0.25	-	465	580	26	115	75	50
EH14	0.10	1.65	0.35	0.025	0.025	0.25	-	520	620	26	120	80	50
EA2	0.10	1.10	0.30	0.025	0.025	0.25	0.50	520	675	24	115	80	50

**WELDING PARAMETERS** - Current up-to 800 amps, Voltage: 24-34 V, Speed: Up-to 1.00 mts/min.

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

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