

## ❖ Product Description

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| I. Agglomerated fluoride basic type of flux                           | IV. Current type DCEP/AC                        |
| II. Basicity index ~ 1.5  | V. Comes with grain size ranges from 0.25-2.0mm |
| III. Suitable for Carbon Steel for speed ranges between 0.4-0.6 m/min |   |

## ❖ Range of Application

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|-------------------------------|---|
| I. General Structural Welding | II. Fabrication of boiler and pressure vessel |
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## ❖ Classification

AWS/SFA 5.17 F6A2-EL8	AWS/SFA 5.17 F6A2-EL12
AWS/SFA 5.17 F7A2-EM 12K	AWS/ SFA 5.17 F7A4/P4 EH14

## ❖ % Chemical Composition of Weld Deposits (weight %)

With Wire	C	Mn	Si
EL 8	0.06	0.85	0.40
EL 12	0.07	0.90	0.40
EM 12K	0.07	1.20	0.50
EH 14	0.07	1.50	0.40

## ❖ Mechanical Properties of all weld metal

Wire Type		UTS, Mpa	Ys, Mpa	% E	CVN Impact		
					-20°	-30°	-40°
EL 8	As welded	470	390	28	50	-	-
EL 12	As welded	480	390	27	50	-	-
EM 12K	As welded	510	430	27	-	40	-
EH 14	As welded	510	430	30	-	-	40
EH 14	Post Weld	510	430	30	-	-	50

## ❖ Chemical Composition of Flux (% wt)

	SiO <sub>2</sub> + TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	CaO + TiO <sub>2</sub>
Typical Values	15%	30%	35%	20

## ❖ Packaging

Available in 25 kg HD Poly lined Bag

### Special Notes: -

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| (1) All the value above mentioned are typical values. | (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding. |
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### **SHAKUNT ENTERPRISES PRIVATE LIMITED**

**Corporate Office:** - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102  
E-Mail:- [info@shakunt.com](mailto:info@shakunt.com)

**Ludhiana Works:-** B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

**Dharwad Works:-** Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

**Vadodara Works:-** 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA