

❖ Product Description

- | | |
|--|---|
| I. Basic Type Flux | III. Works well with Carbon steel and Low alloy steel |
| II. Suitable for multi-pass welding and fillet welding | |

❖ Range of Application

- | | |
|--|--|
| I. Heavy Engineering Equipment Fabrication | III. Long seam and Cir seam welding of various pipes |
| II. Engineering fabrication of pressure vessel and boilers | IV. Structural Welding |

❖ Classification

AWS/SFA 5.17F7A4-EM12K & AWS/SFA 5.17 F7A4/P4-EH14

❖ % Chemical Composition of Weld Deposits (weight %)

F7A4-EM12K (With 4.00mm Wire Dia.Size)	Typical Values	C	Mn	Si	P	S
		0.08	1.17	0.6	0.022	0.017

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -40°C
As Welded	510	410	27	46,35,48,49,52=47.6 J Average

❖ Flux Sieve Analysis

Mesh Size	2.00	1.70	1.40	1.18	1.00	0.850	0.50	0.250
Typical Values	2.1%	5.6%	14%	4.2%	27.3%	5.5%	39.5%	1.20%

❖ Packaging

Available in 25 kg HD Poly lined Bag

Special Notes: -

- (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.

SHAKUNT ENTERPRISES PRIVATE LIMITED

Corporate Office: - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102
E-Mail:- 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](#)