

Superior Quality Submerged Arc Welding Wire and Flux



RAAJRATNA offers wide range of SAW wire and flux with flexible choice for welding plain carbon, low alloy high tensile and high alloy stainless steels. The fluxes can be used with solid wires and these can be used both single wire as well as multiple wire installations. Our fluxes are capable of providing high welding speeds.

The SAW wire product range also include various grades of copper coated solid wires which have special characteristics like smooth surface, thin and uniform copper coating. Special bright mirror surface of our stainless steel SAW wires ensure good conductivity useful for high speed feeding.

RAAJRATNA produce high quality SAW wire and flux of various grades, with latest and innovative technology to meet National and International standards.



Raajratna
electrodes pvt. ltd.

An ISO 9001:2008 Company and Government Recognized Export House

Submerged Arc Welding Wire and Flux

Solid Wire Classification & Chemical Composition

Grade	AWS Classification	C	Mn	Si	S	P	Cu	Mo
RAAJSAW-1	AWS : A 5.17 EL8	0.10 max.	0.25-0.60	0.07 max.	0.030 max.	0.030 max.	0.35 max.	---
RAAJSAW-2	AWS : A 5.17 EM12K	0.05-0.15	0.80-1.25	0.10-0.35	0.030 max.	0.030 max.	0.35 max.	---
RAAJSAW-3	AWS : A 5.17 EH14	0.10-0.20	1.70-2.20	0.10 max.	0.030 max.	0.030 max.	0.35 max.	---
RAAJSAW-A2	AWS : A 5.23 EA2	0.05 - 0.17	0.95 - 1.35	0.20 max.	0.025 max.	0.025 max.	0.35 max.	0.45 - 0.65

Raajratna also offers stainless steel saw wires as per classification AWS/SFA 5.9.

Flux Description & Application

Grade & Classification Grain Sizes : 8 x 60 BSS	Chemical Composition of Weld Metal (Typical)					Typical Value of Mechanical Properties					Description	Application
	C	Mn	Si	S	Others	YS N/mm ²	UTS N/mm ²	Impact				
								% Elong	J	°C		
RAAJMELT-1 AWS : A 5.17 F7A0-EL8 B. I. = 0.80	0.085	1.10	0.60	0.020	P 0.018	450	530	28	80	0	General purpose SAW flux for welding mild steel and medium tensile steels to get X-ray quality welds.	Structural, offshore platforms, ships, pressure vessels and boilers involving steels.
RAAJMELT-2 AWS : A 5.17 F7A2 EM12K B. I. = 0.85	0.080	1.60	0.60	0.020	P 0.021	450	550	24	80	-20	Agglomerated Si & Mn alloying submerged arc welding flux for the high speed welding of both butt and fillet welds in structural steel components.	Application in low and medium tensile steels in combination with wire grade EL8 & EM12K.
RAAJMELT-3 AWS : A 5.17 F7A2-EH14 B. I. = 1.20	0.10 max.	1.30 to 1.75	0.60 max.	0.030 max.	P 0.030 max.	400-480	480-650	22-28	50	-20	Agglomerated basic flux for having a very high current carrying capacity in both AC & DC.	Suitable for single and multipass welding in structures, pressure vessels, boilers etc.
RAAJMELT-SPL AWS : A 5.17 F7 A2-EA2 B. I. - 1.50	0.070	1.15	0.25	0.018	P Mo 0.45	520	610	22	40	-20	An agglomerated aluminates basic type submerged arc welding flux for very high current carrying on AC & DC. The flux can be used with EL8, EM12K, EH14 and EA2.	Suitable for fillet welding and single or multi pass butt welding with low, medium and high tensile steels.
RAAJMELT-4 AWS : A 5.17 F7 A5-EM12K B. I. - 1.50	0.080	1.60	0.35	0.014	P 0.021	480	550	24	50	-46	An agglomerated aluminates basic type submerged arc welding flux for very high current carrying on AC & DC. It gives impact resistance sub zero and minus temperature.	It is used for welding general structural steels, pressure vessels, pipe steel as well as fine grain steels, boiler drums.
RAAJMELT-6 AWS A 5.17 F7 A2-EM12K B. I. = 0.80	0.070	1.40	0.60	0.010	P 0.015	450	570	24	40	-20	An agglomerated acidic Si, Mn alloying rutile Aluminates type flux specially designed for butt and fillet high speed welding. Suitable for SA welding for low and medium tensile steels and for pipe welding.	The excellent welding properties associated with the acid slag system and hence suitable for high travel speed such as spiral
RAAJMELT-SS DIN 32 522 (Chemical Under ER308L Wire) B. I. = 1.20	0.030 max.	1.50 max.	0.90 max.	-	Cr 19.50 Ni 9.00 min.	320 min.	500 min.	35 min.	75 min.	+20	A special basic welding flux used for welding S. S. and heat resistant steels in combination with the wire electrodes of AWS/SFA 5.9 in respect to the weld metal, that flux is neutral.	It is suitable for joint welding on high alloy Cr-Ni steels type : AISI 304, 304L, 316, 316L, 347, 321, 318, 410, 430 etc.

RING PACK : Precision layer wound

SAW WIRE DRUM : Saw wire Drum packing in 500 Kgs bulk quantity

Standard Sizes :

Dia in mm	2.0	2.4 / 2.5	3.2	4.0	5.0
Dia in Inch	0.078	0.094 / 0.098	0.125	0.157	0.196

Identification : Coils are identified with label showing type (grade), size, quantity and batch / lot numbers.

Saw Wire Packing : Layer wound on steel / MS / fibre strips in 20/30 Kgs.

Saw Flux Packing : Polythene lined paper bags of 25 Kgs or steel drum of 250 Kgs.



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Manufacturer-Exporter of Welding Consumables

Regd. Office : 11, Sona Roopa, Opp. Lal Bunglow, C. G. Road, Navrangpura, Ahmedabad-380 006. Gujarat (India)

Phone : +91-79-2644 5258, 2656 1321, 2643 1543 Fax : +91-79-2656 8085, 2754 3085

e-mail : (For Domestic) sales@raajratnaelectrodes.com / (for International) exports@raajratnaelectrodes.com

For more details please visit us on www.raajratnaelectrodes.com