

RAAJMELT-6

An Agglomerated Manganese-silicate type submerged arc welding Flux for High Speed Welding

CLASSIFICATION: - AWS: SFA/A 5.17

F7AZ-EL8

F7A2-EM12K

CHARACTERISTICS: - RAAJ MELT 6 is an agglomerated acidic Si, Mn alloying Rutile - Aluminate type Flux specially designed for butt and Fillet welding high speed type. RAAJ MELT 6 is suited for SAW welding for low, medium tensile steels and for welding pipes. The Flux exhibits excellent slag removal and exceptional bead finish. The Flux also is associated with acid slag system, allowing high speed coupled with significant Si, Mn pick up, where butt welding is involved with medium this plate subjected to single or small number of passes, with no risk of any type of weld defect.

B.I.: about 0.80

TYPICAL APPLICATION: - RAAJ MELT 6 possesses all excellent welding properties associated with acid slag system and hence very much suitable for high travel speed welding such as spiral welding of pipes where weld shape, easy slag removal and surface finish are necessary. The Flux is specially designed for said applications and contribute also for 'ECONOMY WELDING'

Drying requirement: - Re drying recommended at 300°C for 2 hour before use.

All Weld Metal Chemical composition (Typical %)

UNDER Wires	C	Mn	Si	S	P
RAAJSAW-1	0.060	1.20	0.70	0.010	0.014
RAAJSAW-2	0.070	1.40	0.60	0.010	0.015

All Weld Metal Mechanical properties (Typical)

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	
				0°C	-20°C
RAAJSAW-1	460	540	25	50 J	-----
RAAJSAW-2	450	570	24	60 J	40 J

Raajratna offer a wide range of submerged Arc welding Fluxes for different critical applications.

PACKING SPECIFICATION: - packed in polythene-line paper bags of 25.00 kg net weight.

Be supplied on customer packing against specific request...