RAAJMELT-61

Calcium-Manganese Silicate type agglomerated submerged arc welding Flux for High Speed Welding

CLASSIFICATION: - AWS: SFA/A 5.17

F7A0-EL8
F7A2-EM12K

B.I: 1.10
Mesh Size: 10X60BSS (0.25-1.68mm)
Density: 1.20 kg/dm3

CHERACTERISTICS:- Agglomerated, Natural basicity, calcium-manganese silicate type high speed welding flux with excellent slag detachability and smooth weld bead.it is welding with single and multi-wire procedure with DC or AC current,
Due to high alloys the flux is welding up to 20mm in joining applications.

TYPICAL APPLICATION: - it is suitable for general construction, welding on structural steel, pressure vessels and water pipes, feasible for welding on a little rusty or oily plates also,
It is suited for twin and multi wire welding and well suited in high speed welding especially for spiral pipe mills and also high speed beam welding,

Drying requirement: - Redrying recommended at 350°C for 2 hour before use.

Main Constitutions (%)

SiO2+TiO2	CaO+MgO	Al2O3+MnO	CaF2
40-50	10-20	30-40	10

All Weld Metal Chemical composition (Typical %)

UNDER Wires	C	Mn	Si	S	P
RAAJSAW-1	0.070	1.10	0.65	0.014	0.025
RAAJSAW-2	0.060	1.30	0.55	0.018	0.020

All Weld Metal Mechanical properties (Typical)

UNDER Wires	YS (N/mm^2)	UTS (N/mm^2)	EL %	CHARPY "V" NOTCH IMPACT AT	
				27°C	-0°C
RAAJSAW-1	460	550	25	50 J	-----
RAAJSAW-2	450	580	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,

RAAJMELT-61 is almost equivalent to the following fluxes
LINCOLN 761
ESAB OK 10.80
AUTOMELT A61