

RAAJMELT-B62

An agglomerated Fluoride-basic type submerged arc welding flux for high Impact toughness

CLASSIFICATION: - AWS: SFA/A 5.17 F7A5-EM12K, F7P5-EM12K
 AWS: SFA/A 5.17 F7A5-EH10K, F7P5-EH10K

Classification of Flux EN 14174: SA FB 1 55 DC
 Grain Size = 10 X 60 BSS (0.25-1.60mm)

Basicity Index = 3.20
 Density: 1.10gm/cc

CHARACTERISTICS: - RAAJMELT-B62 Fluoride-Basic flux for suitable high strength fine grain structural steels, as well as cryogenic steels and steels of resistant to aging. Owing its natural behavior as regards pick-up and burn-out of Si and Mn, Neutral metallurgical behavior of this flux when the flux is weld-able with almost every wire electrode.

TYPICAL APPLICATION: It is suited for tandem and multi-wire welding. This flux is suitable to be employed for welding offshore compounds, Flux for welding general structural steels, pressure vessels, pipe steels, as well as fine grain steels

Drying requirement: - Re-drying recommended at 350°C for two hour before use.

Main Constitutions (%)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
15	40	20	25

Typical All Weld Metal Chemical composition (%)

under Wires	C	Mn	Si	S	P
RAAJSAW-2	0.070	1.20	0.25	0.010	0.015
EH-10K	0.090	1.38	0.25	0.015	0.020

Typical All Weld Metal Mechanical Properties

under Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CVN Impact at	
				-50°C	-60°C
RAAJSAW-2	440	560	28	60 J	47 J
EH-10K	470	580	26	70 J	50 J

Size of wire (mm)	Size of wire (inch)	Current Condition Amps.(DC+)	Voltage (V)	Electrodes Extension	Travel speed (mm/sec.)±0.5
2.40/2.50	3/32"	350-450	25-30	19-32	6.0
3.15/3.20	1/8"	425-525	26-34	25-38	6.5
4.00	5/32	475-575	26-34	25-38	7.0
5.00	3/16	575-650	28-36	25-40	7.5

Raajratna offer a wide range of submerged Arc welding Fluxes for SA welding.

PACKING SPECIFICATION: - packed in polythene-line paper bags of 25.00 kg net weight. Tailor made packing on request.