

❖ Product Description

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|---|---|
| I. Aluminate rutile type of agglomerated flux | V. Works well with Carbon steel and Low alloy steel for single and multi-pass application |
| II. Compatible for fillet and butt welding | VI. With EM 12K wire neutrality number is 85 |
| III. Basicity index is around 0.6 | |
| IV. Type of current DC/AC and up to 1000 Amp. | |

❖ Range of Application

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| I. Fabrication of H & I beam for pre-engineered buildings | II. Boilers |
| | III. Structural Fabrication |

❖ Classification

AWS/SFA 5.17F7AZ-EM12K, AWS/SFA 5.17F7AZ-EL8, AWS/SFA 5.17F7AZ-EL 12

❖ % Chemical Composition of Weld Deposits (weight %)

F7AZ-EM12K (With 1.60mm Wire Dia.Size)	C	Mn	Si	P	S
Typical Values	0.06	1.60	1.30	0.022	0.017

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ 0°C
As Welded	518	441	29	40

❖ Flux Sieve Analysis

Mesh Size	2.00	1.70	1.40	1.18	1.00	0.850	0.50	0.250
Typical Values	0.8%	4.2%	23.91%	4.8%	28.9%	4%	30.5%	3.1%

❖ 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.

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