



FEAT CRAFT HS2000m SUBMERGED ARC FLUX



**RECOMMENDED FOR AUTOMATIC AND
SEMI-AUTOMATIC SUBMERGED ARC WELDING**
(Manufactured under quality system certified to ISO9001:2008)

SPECIFICATION AND COMPLIANCE

AWS : A5.17/ A5.23 F7A0 EL12, F7A2-EM12K

DESCRIPTION

HS2000m is an agglomerated, Aluminate Rutile flux for submerged arc welding. It is an active alloying acid flux, insensitive to rust, scale, undercoat, and dirt. This flux offers excellent porosity resistance and good moisture tolerance. It features a smooth soft arc, good slag detachability, wide flat bead shape, and slow freezing slag. This makes it well suited to circumferential welding of tanks and vessels. It is not recommended for welding of more than 3 layers due to its active characteristics. Applications include tanks, pressure vessels, structural steel, pipeline steels and LPG cylinders.

SPECIFICATION

BI	Density	Grain Size	Polarity
0.7	1.40g/cm ³	10-40mesh	DCEP / AC

FLUX COMPOSITION (Wt%)

COMPONENT	SiO ₂ +TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	S	P	Metal alloys
CONTENT	18	3	62	11	≤0.03	≤0.04	≤4

WELD DEPOSIT MECHANICAL PROPERTIES

Flux / Wire Combination	Tensile Strength (Mpa)	Yield Strength (Mpa)	Elongation (%)	Impact Value (J)	
				0°C	-29°C
EL12	520	450	30	95	/
EM12K	600	520	28	/	80



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