

ULTRA A82

SAW FLUXE

GENERAL DESCRIPTION:

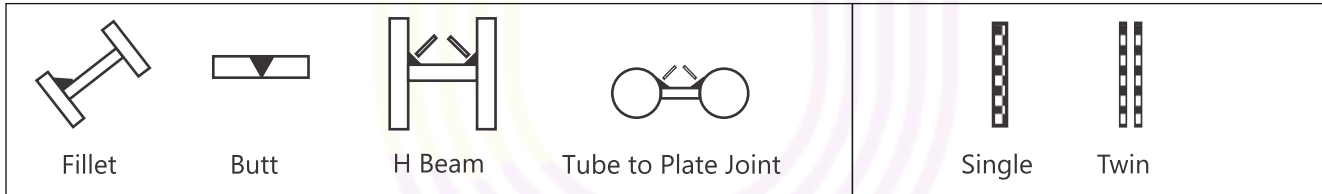
- Agglomerated Flux
- Aluminate- Rutile Type Flux
- Acidic Flux having Basicity Index of 0.6
- Active Flux with moderate Si and Mn pick-up
- For Single and Multi-pass Butt and fillet welding at very high speeds
- For Low Alloy Steels
- Suitable for Single and twin Wire system
- Suitable for Welding Speeds of 0.40-2.0 m/min
- Grain Size – 0.25-1.20 mm
- Type of Current – DC / AC 1000A
- Wall Neutrality Number with EM12K Wire is 85

CLASSIFICATION :

With Wire	AWS 5.17/5.23	Single / Multi-pass
ULTRAMET EL8	F7AZ-EL8	Limited Multi-pass
ULTRAMET EL12	F7AZ-EL12	Limited Multi-pass
ULTRAMET EM12K	F7AZ-EM12K	Limited Multi-pass

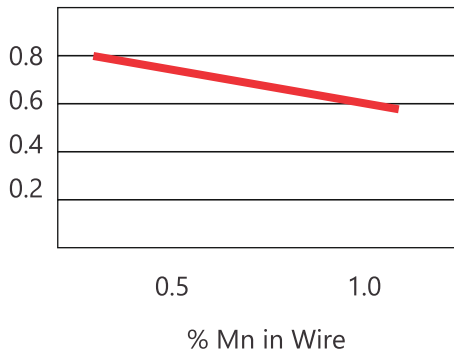
TYPICAL APPLICATIONS :

- Structural Welding
- High Speed Fillet Welding
- Fabrication of H & I Beams
- Fabrication of Boilers

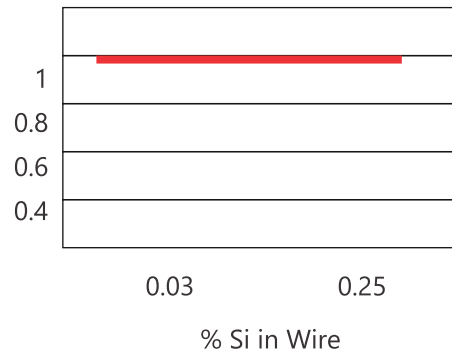


ACTIVITY OF THE FLUX:

% Mn Pick-up from the flux



% Si Pick-up from the flux



CHEMICAL COMPOSITION OF FLUX:

SiO₂ + TiO₂	CaO + MgO	Al₂O₃ + MnO	CaF₂
25	10	50	10

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:

With wire	C	Mn	Si
ULTRAMET EL8	0.06	1.20	1.00
ULTRAMET EL12	0.07	1.20	1.00
ULTRAMET EM12K	0.06	1.60	1.30

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact (J) 0°C
ULTRAMET EL8	AW	550	460	22	40
ULTRAMET EL12	AW	560	460	23	40
ULTRAMET EM12K	AW	560	470	23	40

AW – As Welded

The chemistry and mechanical properties will depend on actual wire chemistry and arc voltage