



SAW FLUX AV EZEWELD 132

CLASSIFICATION

Flux & Wire combination

AV EZEWELD Flux 132 - EM12K

AV EZEWELD Flux 132 - EA2

SPECIFICATION

ASME BPVC SEC II C SFA 5.17 / 5.23

AWS A 5.17 - F8A5/F8P5 - EM12K

AWS A 5.23 - F9A5/F9P4 - EA2

AWS A 5.23 - F8TA5 - EA2

Description

AV EZEWELD Flux 132 is an aluminate-basic type flux designed for welding pipes from both sides in one pass. AV EZEWELD Flux 132 is characterised by its high current carrying capacity in multi-wire welding processes. Even at very high currents the welding process remains stable. The weld seam shows very good bead shape and a very broad, flat profile. AV EZEWELD Flux 132 can also be used in multi-run applications with Ni-Mo and other alloyed wires for required mechanical properties and chemical properties.

Typical Application

AV EZEWELD Flux 132 is an excellent choice for welding API Pipes for oil and gas industry up to X80. It is suitable for one-pass pipe welding from both sides in high-productivity SAW operations, particularly where multi-wire welding with high current levels is required. The flux is also suitable for multi-run welding applications when used with Ni-Mo and other alloyed wires for required mechanical properties and chemical properties. Owing to its stable welding behaviour and controlled weld metal properties, AV EZEWELD Flux 132 is a well-suited SAW Flux for gas pipeline welding applications.

BASICITY INDEX 1.5

Typical all weld metal chemical and mechanical properties

AV EZEWELD 132	Chemical Composition						Mechanical Properties			
	C %	Mn %	Si %	S %	P %	Mo %	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Value Charpy
EM12K	0.1	1.4	0.3	<0.03	<0.03	-	480	570	27	60J at (-) 40°C
EA2	0.1	1.6	0.4	<0.025	<0.025	0.45	645	709	22	40J at (-)40°C

*Typical values in as welded condition

Note on Usage

Redry Flux at 300-350 °C for 2 hours before use

Packaging data

Poly Lined HDPE Bags - Weight 25 Kg (standard)

HDPE Bags in Jumbo Bag - Weight 1 MT (40 bags x 25 Kg each)

HDPE Bags on palette - Weight 1/1.25 MT (40/50 bags x 25 Kg each)