



## SAW FLUX AV EZEWELD 17L

### CLASSIFICATION

#### Flux & Wire combination

AV EZEWELD Flux 17L – EM12K

AV EZEWELD Flux 17L – EH14

AV EZEWELD Flux 17L – EA4

### SPECIFICATION

ASME BPVC SEC II C SFA 5.17/5.23

AWS A5.17 F7A5/P5 – EM12K

AWS A5.17 F8A4/P5 – EH14

AWS A5.23 F9A5/P4 – EA4

### Description

AV EZEWELD 17L is an aluminate basic agglomerated flux for Submerged Arc Welding bearing very high current carrying capacity. It has very good properties for both single wire and multi wire systems. It gives excellent impact values at very low temperatures and also very low oxygen in welding.

### Typical Application

AV EZEWELD 17L can be used for fillet welding and Single/Multi pass butt welding of mild, medium and high tensile steel. The required strength of weld metal is achieved by proper selection of alloyed wire. It is used for narrow gap welding due to superior slag detachability and smooth blending of weld bead with side walls. This Flux is used for welding of boilers, pressure vessel, structural fabrications requiring high mechanical properties.

### BASICITY INDEX 1.6

### Typical all weld metal chemical and mechanical properties

AV EZEWELD 17L	Chemical Properties						Mechanical Properties			
	C %	Mn %	Si%	Mo%	S%	P%	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elonga- tion %	Impact Value Charpy
EM12K (AW)	0.07	1.2	0.6	-	<0.025	<0.025	460	550	28	50J at -40°C
EM12K (PWHT)	0.07	1.2	0.6	-	<0.025	<0.025	450	540	227	60J at -40°C
EH14 (AW)	0.10	1.8	0.30	-	<0.025	<0.025	480	570	23	40J at -30°C
EH14 (PWHT)	0.10	1.8	0.30	-	<0.025	<0.025	470	560	26	50J at -40°C
EA4 (AW)	0.07	1.4	0.3	0.5	<0.025	<0.025	480	570	24	45J at -40°C
EA4 (PWHT)	0.07	1.4	0.3	0.5	<0.025	<0.025	480	570	24	45J at -30°C

\*AW- As Welded \*PWHT – Post Weld Heat Treated at 620°C for 3 hours

### 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)