



### SAW FLUX AV EZEWELD GR 187

#### CLASSIFICATION

##### Flux & Wire

AV EZEWELD Flux 187 – EL8

AV EZEWELD Flux 187 – EM12K

#### SPECIFICATION

ASME BPVC SEC II C SFA 5.17

AWS A5.17- F7A0/P0 – EL8

AWS A5.17- F7A2/P2 – EM12K

#### Description

AV EZEWELD 187 is an agglomerated acidic silicon and manganese alloying flux for Submerged Arc Welding. It has excellent welding characteristics for high speed welding with uniform and good bead appearance. Slag removal after welding is easy and self-peeling in most cases. It offers radiography quality welds with all required mechanical properties.

#### Typical Application

AV EZEWELD 187 is specifically designed for welding of high-mast poles in automatic High-speed Pull Through Welding (PTW) machines, where deposition is required in single run weld. This flux is also suitable for High-speed butt and fillet welding with single pass and multi pass application for high current applications with tandem wire systems. This flux is an excellent choice for high-speed welding of PEB Structures in Pull-through (PTW) welding machine and welding of High-mast poles.

#### BASICITY INDEX 0.8

#### Typical all weld metal chemical and mechanical properties

AV EZEWELD 18L(Z)	Chemical Composition					Mechanical Properties			
	C%	Mn%	Si%	S%	P%	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact Value Charpy
EL8	0.07	0.80	0.40	<0.03	<0.03	460	550	27	40J at 0°C
EM12K	0.08	1.20	0.40	<0.03	<0.03	450	580	25	45J at 20°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)