



## SAW FLUX AV EZEWELD 18L

### CLASSIFICATION

#### Flux & Wire combination

AV EZEWELD Flux 18L - EL8

AV EZEWELD Flux 18L - EM12K

### SPECIFICATION

ASME BPVC SEC II C SFA 5.17

AWS A5.17- F7A0/F7P0 – EL8

AWS A5.17- F7A2/F7P2 – EM12K

### Description

AV EZEWELD 18L is an agglomerated silicon and manganese alloying flux for submerged arc welding. This flux provides excellent welding characteristics for high-speed welding. The bead is uniform and good in appearance with no tendency to undercutting. Slag removal is easy and self-peeling in most cases. It offers radiography quality weld.

### Typical Application

AV EZEWELD 18L can be used for all types of application in low and medium tensile steel in combination with EL8 and EM12K wire. This flux is most suitable for butt and fillet welding with single pass and multi passes welding in LPG cylinders, Spiral Pipes, General structural fabrications, etc

### BASICITY INDEX – 1.0

### Typical all weld metal chemical and mechanical properties

AV EZEWELD 18L	Chemical Properties					Mechanical Properties			
	C %	Mn%	Si%	S %	P %	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elonga- tion %	Impact Value CVN
EL8	0.08	0.65	0.40	<0.03	<0.03	460	550	27	50J at 0°C
EM12K	0.07	1.20	0.40	<0.03	<0.03	450	580	29	60J 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)

### APPROVALS

**BHEL** Bharat Heavy Engineering Limited

**IRS** Indian Registrar of Shipping