



## SAW FLUX AV EZEWELD 18L(Z)

### CLASSIFICATION

#### Flux & Wire

AV EZEWELD Flux 18LZ – EL8

AV EZEWELD Flux 18LZ – EM12K

### SPECIFICATION

ASME BPVC SEC II C SFA 5.17

AWS A5.17- F7AZ/PZ – EL8

AWS A5.17- F7A0/P0 – EM12K

### Description

AV EZEWELD 18L(Z) is an agglomerated, acidic Silicon and Manganese alloying flux for Submerged Arc Welding, with **excellent welding characteristics at high-speed welding**. Bead appearance is good and uniform with no tendency to undercut. Slag removal after welding is easy and self-peeling.

### Typical Application

AV EZEWELD 18L(Z) can be used for all types of application in low and medium tensile steel in combination with EL8 and EM12K wires. AV EZEWELD 18L(Z) is suitable for High-speed butt and fillet welding with single pass and multi pass application and 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	-
EM12K	0.08	1.20	0.40	<0.03	<0.03	450	580	25	45J at 0°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)