



## SAW FLUX AV EZEWELD 19L

### CLASSIFICATION

#### Flux & Wire combination

AV EZEWELD Flux 19 - EL8

AV EZEWELD Flux 19 - 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 19 is an agglomerated, acidic, aluminate-rutile flux for Submerged Arc Welding Flux. It has excellent welding characteristics for medium speed welding applications with clear and uniform bead appearance. Slag removal after welding is easy and self-peeling.

### Typical Application

AV EZEWELD 19 is a proven solution for medium-speed, single-pass fillet and butt welding. Designed for structural PEB applications with trolley-mounted SAW machines, it ensures consistent welding performance and produces a smooth, shiny weld bead at speeds of 400–700 mm/min.

### BASICITY INDEX - 1

### Typical all weld metal chemical and mechanical properties

AV EZEWELD 19	Chemical Composition					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 Charpy
<b>EL8</b>	0.07	0.80	0.40	<0.03	<0.03	460	550	27	45J at 0°C
<b>EM12K</b>	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)