



## SAW FLUX AV EZEWELD 26

### CLASSIFICATION

#### Flux & Wire

AV EZEWELD Flux 26 – EM12K

AV EZEWELD Flux 26 – EH10K

AV EZEWELD Flux 26 – EA2

### SPECIFICATION

ASME BPVC SEC II C SFA 5.17/5.23

AWS A5.17 F8A6/P6 – EM12K

AWS A5.17 F9A8/P8 – EH10K

AWS A5.23 F8A5/P4 – EA2

### Description

AV EZEWELD 26 is an all-mineral non-alloying submerged arc welding flux for special applications where the weld metal chemistry can be fully controlled independently of the welding parameter through suitable choice of wires. This makes AV EZEWELD 26 suitable for multirun welding of thick material using single wire as well as multi-wire technique. It allows high current capacity on DC+ where it is especially suited for narrow gap welding due to its excellent slag detachability and smooth blending with sidewalls.

### Typical Application

AV EZEWELD 26 is designed for multiple pass welding of medium and high tensile steels as well as low alloyed steel with high impact strength requirement between -40 °C and -60 °C. Critical designed pressure vessel where good CTOD values required are required. AVEZEWELD 26 gives weld metal a low oxygen content (approx. 300ppm) and low hydrogen content deposit (Lower than 5ml/100g)

### BASICITY INDEX 2.9

### Typical all weld metal chemical and mechanical properties

AV EZEWELD 26	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)	0.10	1.2	0.60	-	<0.025	<0.025	480	570	27	40J at -50°C
EM12K (PWHT)	0.10	1.2	0.60	-	<0.025	<0.025	490	580	26	50J at -50°C
EH10K (AW)	0.10	1.6	0.40	-	<0.025	<0.025	580	660	22	40J at -60°C
EH10K (PWHT)	0.10	1.6	0.40	-	<0.025	<0.025	580	660	21	50J at -60°C
EA2 (AW)	0.10	1.2	0.25	0.47	<0.025	<0.025	550	650	26	55J at -40°C
EA2 (PHTW)	0.10	1.2	0.25	0.47	<0.025	<0.025	540	640	29	60J at -30°C

\*AW- As Welded \*PWHT – Post Weld Heat Treated at 620°C for 1 hour \*Polarity – DC+

### 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)