

S.A.W WIRE & FLUX

## RASI FLUX EL-8

SUBMERGED ARC WELDING FLUX

### CLASSIFICATION :

ASME SEC-II, PART 'C'  
SFA 5.17 AWS : F7AZEL-8

### CHARACTERSTICS :

**RASI FLUX EL-8** is agglomerated all purpose Si-Mn flux for SAW welding, the weld metal is radiographically sound.

### APPLICATIONS :

Ship buildings, bridges, machinery parts, MS structural, Locomotive, Penstocks and LPG cylinders.

### CHEMICAL COMPOSITION OF WELD METAL

ELEMENT	C	Mn	SI	S & P
%	0.1 Max	1.0-1.5	0.3-0.6	0.04 Max

### MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm <sup>2</sup> )	YS(N/mm <sup>2</sup> )	Elongation %
480-660	35% Min	22% Min

WELDING CURRENT : DC +700 Amps

PACKING : 25 kgs / bag packed in Polythene Paper Bag : 250°c for 1 Hr

### STORAGE

Re-dry the Flux at 250°C for 1 Hr, use short arc during welding store the flux in dry conditions.

Also available Fused Flux for the same grade on request.