

Standards

TS EN ISO 14174	: SA AR 1 77 AC
EN ISO 14174	: SA AR 1 77 AC
AWS A5.17	: F6AZ-EL12 / F7AZ-EM12

Basicity 0.7

Mechanical Properties

SAW Wire	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)
					0°C
S1	F6AZ-EL 12	360	460	26	47
S2	F7AZ-EM 12	400	500	30	60

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S1	0.07	0.50	1.10
S2	0.07	0.60	1.35

Features and Applications

- A type of SAW rutile flux structured from agglomerated aluminate
- Applicability in single-pass joint welding and fillet welding of particularly spiral welded pipes, LPG cylinders, general-purpose construction steels, boiler sheet, and shipbuilding steels
- Low consumption of flux. Basicity: 0.7
- Straight and nonporous welding beads
- Formation of very easily-removed slag
- Requirement of re-drying at 250-350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800006	25	Kraft Bag

Approvals: S1 x ELIFLUX BAR: BV, DNV-GL, TL, ABS, LR, CE • S2 x ELIFLUX BAR: BV, ABS, CE, DB
 ELIFLUX BAR: CE, SEPRO