

Standards

TS EN ISO 14174	: SA AB 1 67 AC
EN ISO 14174	: SA AB 1 67 AC
AWS A5.17	: F7 A5-EM12 / F7A5-EM12K

Basicity
1.60

Mechanical Properties

SAW Wire	AWS A5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((L ₀ =d ₀) (%))	Impact Strength ISO-V(J)		
					0°C	-40°C	-45°C
S2	F7A5-EM 12	430	520	30	110	75	min.47
S2Si	F7A5-EM 12K	465	570	30	100	85	min.47

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S2	0.05	0.30	1.40
S2 Si	0.06	0.40	1.40

Features and Applications

- SAW flux type composed of agglomerated aluminate-basic
- Basicity: 1.6 (According to Boniszewski formula)
- Applicability in single and multi-pass welding of general-purpose construction steels
- Formation of easily-removed slag
- Requirement of re-drying at 300 - 350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800035	25	Kraft Bag