

Standards

TS EN ISO 14174	: SA CS/MS 1 68 AC
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AWS A5.17	: F6A0-EM12 / F6AZ-EL12

Basicity
1.0

Mechanical Properties

SAW Wire	AWSA5.17	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)	
					0°C	-20°C
S1	F6AZ-EL12	395	475	24	38	---
S2	F6A0-EM12	390	485	30	---	69

Chemical Composition of Weld Metal - % (Typical)

SAW Wire	C	Si	Mn
S1	0.05	0.80	1.10
S2	0.04	0.45	1.27

Features and Applications

- A type of SAW flux structured from agglomerated manganese silicate and calcium silicate
- Basicity of the flux according to Boniszewski formula is 1,0
- Weld beads of excellent surface appearance and with easily removed slags
- High resistance to porosity caused by oil and rust
- High capacity of current flow
- Suitability for use in 2-pass welding operations on thick materials (best choice for base metals in thicknesses of 10-40 mm)
- Requirement of re-drying at 250-350°C for 2 hours

Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800009	25	Kraft Bag

Approvals: S2 / ELIFLUX BMS: BV, ABS, CE

ELIFLUX BMS: CE, SEPRO