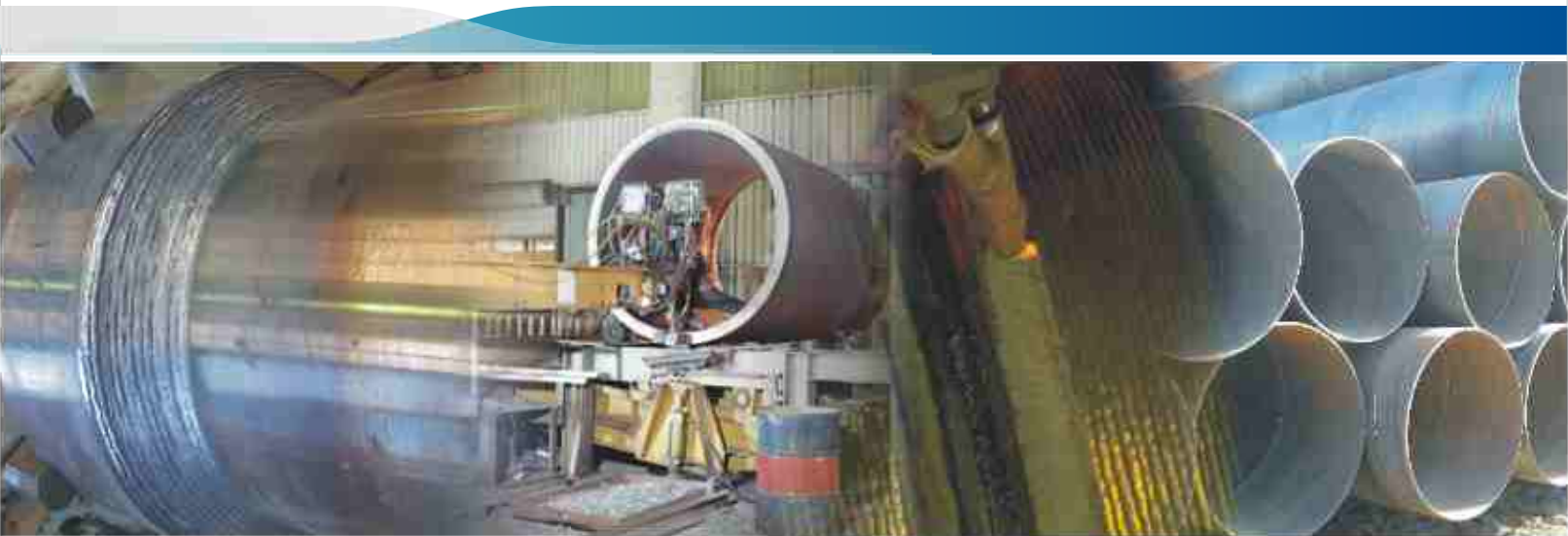




**D & H INDIA LIMITED**  
Formerly 'D & H Welding Electrodes (India) Ltd'

# Agglomerated Fluxes And Wires For Submerged Arc Welding



*High Quality  
High Productivity*

# Agglomerated Fluxes And Wires for Submerged Arc Welding

BRAND NAME	AWS CLASSIFICATION	CHEMICAL - COMPOSITION (%)								MECHANICAL - PROPERTIES				HARDNESS (On two layer deposits) BHN	APPLICATIONS
		C	Mn	Si	S	P	Cr	Mo	Cu	Y.S. MPa (Min)	U.T.S. MPa	ELONG. %(Min)	IMPACT JOULE (Min)		
	<b>AWS - SFA - A 5.17</b>														
SUPERMELT-I	F-6AO-EL8	0.10 Max	1.0-1.60	0.55 Max	0.03 Max	0.03 Max	-	-	-	330.0	430-560	22.0	27-J at -20° C	-	General purpose fabrication flux suitable for single or multiple pass welding of carbon and low alloy steel such as IS-2062, IS-2002, A-515 Gr.60 etc. Also suitable for sheet metal fabrication.
SUPERMELT-II	F-7AZ-EL8	0.10 Max	1.10-1.80	0.25 -0.55	0.03 Max	0.03 Max	-	-	-	400.0	480-660	22.0	27-J at -R.T.	-	Recommended for fillet & butt weld joint in single or multiple pass welding. Suitable for pressure-vessels, structural steel, ship building, locomotives, automobiles, LPG cylinders, SAW pipes etc.
SUPERMELT-III	F-7AO-EL8	0.10 Max	1.40-1.80	0.25 -0.55	0.03 Max	0.03 Max	-	-	-	400.0	480-660	22.0	27-J at -20°C	-	Suitable for single & multiple pass welding of mild steel and high tensile steel application requiring high strength and sub zero impact properties, suitable for pressure vessels, Nuclear fabrication, ship building, earth moving equipment and penstoke shell etc.
SUPERMELT-IV	F-7A2 EH-14 F-7P2 EH-14	0.10 Max	1.30-1.80	0.50 Max	0.03 Max	0.03 Max	-	-	-	400.0	480-660	22.0	27-J at -30°C	-	Suitable for welding carbon and low alloy steels for meeting requirements of high strength tensile and impact requirement at sub zero temperature down to -30°C Suitable for pressure vessels and other fabrication involving steels such as IS-2002 Gr. 2B, A515/516 Gr. 70, DIN-17155 HV, BS 1501-151-32A & B, API-2H steels etc.
SUPERMELT-IV (SPL)	F-7A2-EL8 F-7P2-EL8	0.10 Max	1.30-1.80	0.50 Max	0.03 Max	0.03 Max	-	-	-	400.0	480-660	22.0	27-J at -30°C	-	Application of supermelt IV(SPL) are exactly identical with that of supermelt IV with additional advantage of obtaining similar quality deposit having same chemical and mechanical properties by using economical supermelt Gr. A (EL-8 grade) wire
SUPERMELT-V	F-7AZ/PZ EL8	0.10 Max	1.20-1.70	0.30-0.60	0.03 Max	0.03 Max	-	-	-	400.0	480-660	22.0	27-J at RT	-	SUPERMELT-V is excellent silico-aluminate type flux for high speed welding with exceptionally good welding characteristics. The flux produces high quality of weld metal with self removable slag. Highly suitable for narrow gap welding, recommended for single and multiple welding of structural steel, boilers, heavy machinery, bridges, ship, H-beam, Agricultural implements and general fabrication.
SUPERMELT-HFA	-	0.25 Max	1.80 Max	1.20 Max	0.03 Max	0.03 Max	2.0 Max	0.20 Max	-	-	-	-	-	240-280	Economical hardfacing flux with supermelt-Gr. A(EL-8 grade) wire produces sound machinable deposit having high impact and low abrasion resistance properties, suitable for surfacing of rolls, tracks & wheels and other applications where wear is mainly due to rolling or sliding friction.
SUPERMELT-HFB	-	0.25 Max	1.80 Max	1.20 Max	0.03 Max	0.03 Max	3.5 Max	0.50 Max	-	-	-	-	-	340-380	Hardfacing flux with supermelt Gr. A (EL-8 grade) wire produces C, Mn, Cr, Mo, alloy deposit having high impact and medium abrasion resistance properties, deposit is machinable with appropriate tool, Suitable for hardfacing of ditcher rolls, track rollers, pulley brakes, skip wheels & crane wheels etc.
SUPERMELT-HFC	-	0.25 Max	1.80 Max	1.20 Max	0.03 Max	0.03 Max	5.00 Max	1.20 Max	-	-	-	-	-	600-650	Exclusively developed for hardfacing application in combination with EL-8 grade wire. The alloyed weld deposit is highly resistance to severe abrasion and impact, very useful in reclaiming costly wornout machine parts and on wide varieties of hard surfacing applications. The deposits are non - machinable
	<b>AWS - SFA - A 5.17</b>	<b>Submerged Arc Welding Wires</b>													
SUPERMELT-Gr A	EL-8	0.10 Max	0.25-0.60	0.07 Max	0.03 Max	0.03 Max	-	-	0.35 Max	-	-	-	-	-	Copper coated mild steel wire, can be used on variety of applications with appropriate combination of submerged arc flux.
SUPERMELT-Gr B	EH-14	0.10 -0.20	1.70-2.20	0.10 Max	0.03 Max	0.03 Max	-	-	0.35 Max	-	-	-	-	-	Copper coated high manganese bearing mild steel wire, recommended for medium and high tensile steel welding by submerged arc welding process
SUPERMELT-12 K	EM12K	0.05-0.15	0.80-1.25	0.10-0.35	0.03 Max	0.03 Max	-	-	0.35 Max	-	-	-	-	-	Copper coated medium manganese alloyed wire for submerged arc welding and electroslag welding of medium and high tensile steels.

