

Agglomerated Fluxes And Wires For Submerged Arc Welding

SUPERMELT - IV

AWS Classification (AWS - SFA - A 5.17) - F-7A2 EH-14, F-7P2 EH-14

HARDNESS (on two layer deposits) BHN

APPLICATIONS

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 HIV, BS 1501-151-32A and B, API-2H steels etc.

CHEMICAL COMPOSITION (%)

C	Mn	Si	S	P	Cr	Mo	Cu
0.10 Max	1.30-1.80	0.50 Max.	0.03 Max.	0.03 Max.	--	--	--

MECHANICAL PROPERTIES

Y.S. MPa (Min)	U.T.S. MPa	ELONG. %(Min)	IMPACT Joule(Min)
400.0	480-660	22.0	27-J at -30°C

