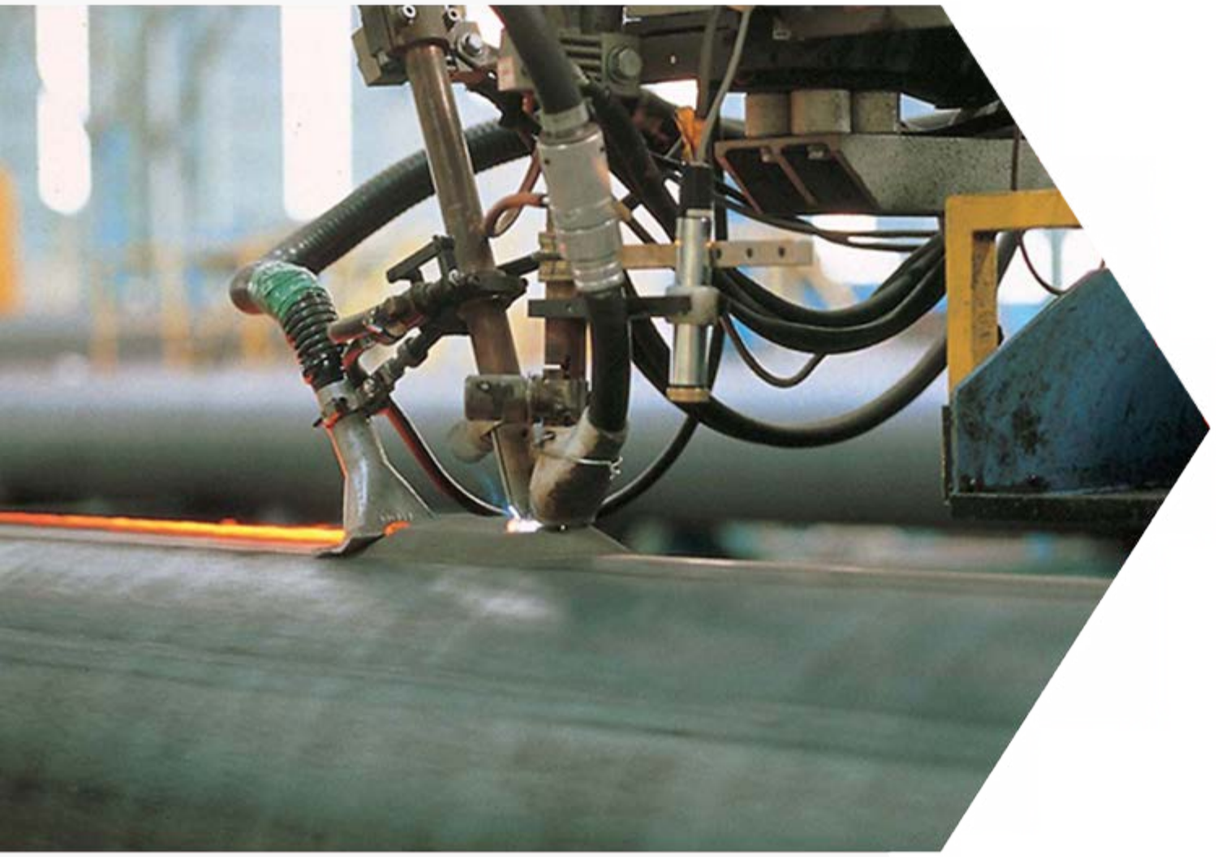
SUBMERGED ARC WELDING
WIRE & FLUX



Submerged arc welding (SAW) is a common arc welding process. It requires a continuously fed consumable solid or tubular (flux cored) electrode. The molten weld and the arc zone are protected from atmospheric contamination by being "submerged" under a blanket of granular fusible flux consisting of lime, silica, manganese oxide, calcium fluoride, and other compounds. When molten, the flux becomes conductive, and provides a current path between the electrode and the work. This thick layer of flux completely covers the molten metal thus preventing spatter and sparks as well as suppressing the intense ultraviolet radiation and fumes that are a part of the shielded metal arc welding (SMAW) process.

S.A.W. WIRE
RASI® EL - 8 WIRE
COPPER COATED CONTINUOUS SOLID WIRE FOR SUBMERGED ARC WELDING

CLASSIFICATIONS

ASME SEC-II, PART 'C'
SFA 5.17 GRADE: EL – 8

CHARACTERISTICS

Is a Low Manganese copper coated Mild Steel wire for submerged Arc Welding.

CHEMICAL COMPOSITION OF WIRE

C	Mn	Si	S & P
0.1	0.33 - 0.60	0.03	0.03

MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm^2)	Ys (N/mm^2)	Elongation %
410 - 510	330 Min	22% Min

Note: Single Values are maximum %

PACKING SPECIFICATION : IN COIL FORM

EACH SPOOL IS WRAPPED WITH POLYTHENE

PRECAUTIONS: Choose the suitable flux for welding. Use short arc

INNER DIAMETER	300 mm
WIDTH	100 mm
WEIGHT	25 Kgs Net.

CHEMICAL COMPOSITION OF FLUX

BRAND	CODING	CHARACTERISTICS
RASI - EL - 8	SFA 5.17 AWS: F7AZ EL-8	Agglomerated and fused flux, all purpose Si - Mn flux for SAW welding
RASI - EM 12 K	F7A6-EM12K / F7P6-EM12K	Agglomerated fully basic flux designed for multi pass welds
RASI - SJ - 101	F4A2-H08MnA / F5A4-H10Mn2	SJ101 is a kind of fluoride-alkalinity and slag-series sintered flux
RASI - SJ - 102	AWS-A5.17 F7A4-EH14:F6A4-EM12K	High basicity sintered flux, basicity 3.0, have a good welding procedure
RASI - WD 8010	F410-H1Cr1 3/F 308-H0Cr21 Ni10	WD - 8010 is an agglomerated Aluminate-basic type flux

Packing: All Flux are packed in 25 Kgs HDPE bags