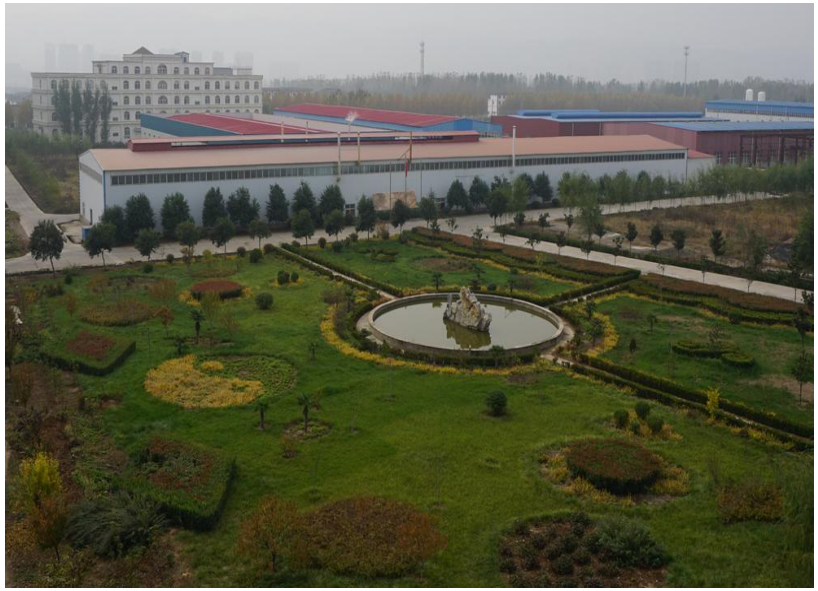
Luoyang Peony Welding Material Group Co.,Ltd

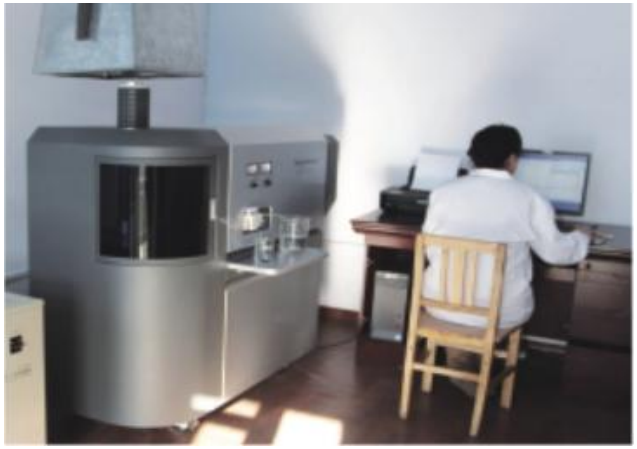
For excellent Quality&Service
We provide

About Luo Yang Peonyweld

LUOYANG PEONY WELDING situated in the historically and culturally famous city of Luoyang- a modern industrial city, is one of the largest manufacturers of welding consumables in China.
LUOYANG PEONY commenced operations in 1985,a leading manufacturer of Submerged arc welding in China,whose product brands are famous as “PEONY” and “HUAWANG”.
There are five productions lines of submerged arc welding flux, which have a capacity of 40,000 tons of welding consumables.
PEONY WELDING under “PEONY”,”HUAWANG” brand provides welding product for the following industrial field:steel constructions; wind tower; pipelines; pressure vessel; gas cylinder; hardfacing;platforms; ship building; nuclear electric power plants and etc..
We have strong research and development ability with 18 senior welding technology engineers offer after sales service for our customers.About quality control,we have complete experimental and testing equipments including chemical analysis,mechanical properties,impact value.We keep a close relation and cooperation with Henan University of Science and Technology.
LUOYANG PEONY WELDING operates under a comprehensive quality management system certified to ISO9001:2008 and the approval of China Classification Society.
We are dedicated to offering more better welding service and saving costs for our customers.
Our mission is to supply the exceptional quality and exceptional service FOR YOU.



Production&Inspection



Certificate Approval

Certificate

Certificate No.: 11415Q22199R1M

This is to certify that the Quality Management System of

LUOYANG MUDAN WELDING MATERIALS GROUP CO., LTD.

Organization Code: 17135310X

Registered Address: Longyu West Road, Industrial Park, Yiyang County, Luoyang City, Henan Province
Production Address: Xianghushan Town, Industrial Park, Yiyang County, Luoyang City, Henan Province
Office Address: Longyu West Road, Industrial Park, Yiyang County, Luoyang City, Henan Province

Has been audited to conform to the following Quality Management System standard

GB/T 19001-2008 idt ISO 9001:2008

This Quality Management System is valid for the

Production of flux for submerged arc automatic welding for its branch company, Henan Mudan Welding Material Co., Ltd.

Initial issued date: Sep. 10, 2012
Date of issue: Sep. 01, 2015
Date of expiry: Aug. 31, 2018

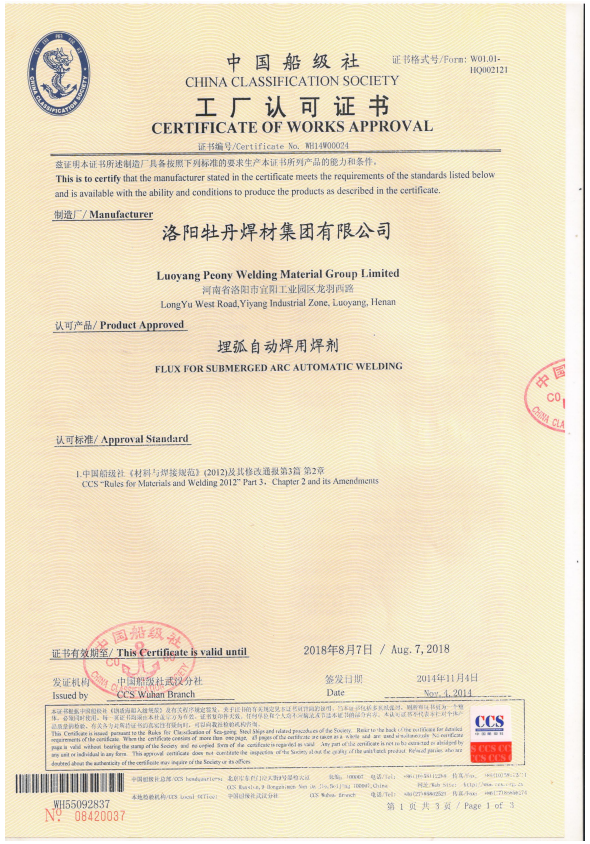
Issued by: BEIJING EASTALLREACH CERTIFICATION CENTER

EACC ISO 9001 IAF CNAS

MANAGEMENT SYSTEM CNAS C114-Q

The 1st Surveillance Conforming Mark | The 2nd Surveillance Conforming Mark | The 3rd Surveillance Conforming Mark

ISO 9001 ISO 9001



中国船级社 CHINA CLASSIFICATION SOCIETY

证书格式号/Form: WO1.01-HQ002121

工厂认可证书

CERTIFICATE OF WORKS APPROVAL

证书编号/Certificate No. WH14W00024

兹证明本证书所述制造厂具备按照下列标准的要求生产本证书所列产品的能力和条件，

This is to certify that the manufacturer stated in the certificate meets the requirements of the standards listed below and is available with the ability and conditions to produce the products as described in the certificate.

制造厂/ **Manufacturer**

洛阳牡丹焊材集团有限公司

Luoyang Peony Welding Material Group Limited
河南省洛阳市宜阳工业园区龙羽西路
LongYu West Road,Yiyang Industrial Zone, Luoyang, Henan

认可产品/ **Product Approved**

埋弧自动焊用焊剂

FLUX FOR SUBMERGED ARC AUTOMATIC WELDING

认可标准/ **Approval Standard**

1.中国船级社《材料与焊接规范》(2012)及其修改通报第3篇 第2章
CCS "Rules for Materials and Welding 2012" Part 3, Chapter 2 and its Amendments

证书有效期至/ **This Certificate is valid until** 2018年8月7日 / Aug. 7, 2018

发证机构 中国船级社武汉分社 CCS Wuhan Branch

Issued by

签发日期 2014年11月4日
Date Nov. 4, 2014

WH155092837

No. 08420037

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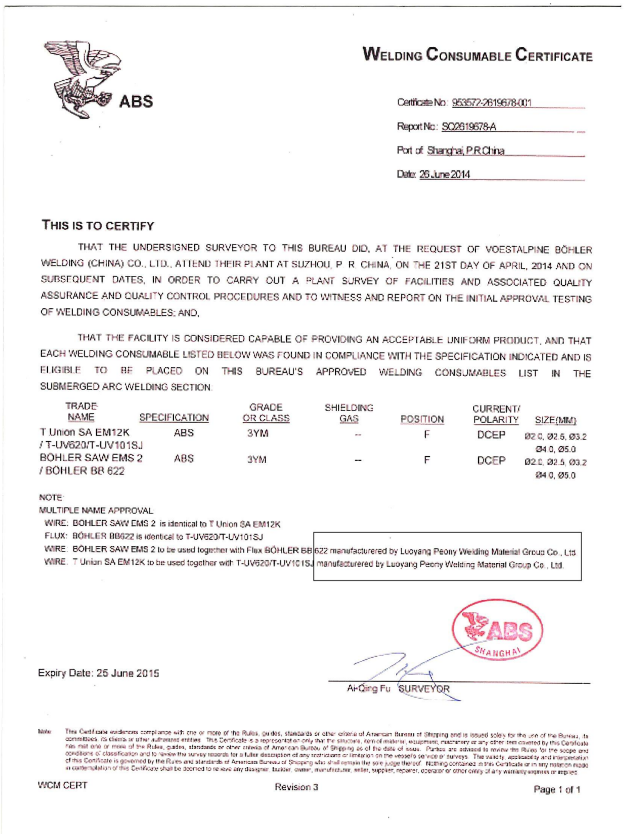

ABS

WELDING CONSUMABLE CERTIFICATE

Certificate No. 953572-2619678-001
Report No.: SC2619678-A
Port of Shanghai, P.R.China
Date: 26 June 2014

THIS IS TO CERTIFY

THAT THE UNDERSIGNED SURVEYOR TO THIS BUREAU DID, AT THE REQUEST OF VOESTALPINE BÖHLER WELDING (CHINA) CO., LTD., ATTEND THEIR PLANT AT SUZHOU P. R. CHINA ON THE 21ST DAY OF APRIL, 2014 AND ON SUBSEQUENT DATES, IN ORDER TO CARRY OUT A PLANT SURVEY OF FACILITIES AND ASSOCIATED QUALITY ASSURANCE AND QUALITY CONTROL PROCEDURES AND TO WITNESS AND REPORT ON THE INITIAL APPROVAL TESTING OF WELDING CONSUMABLES; AND,

THAT THE FACILITY IS CONSIDERED CAPABLE OF PROVIDING AN ACCEPTABLE UNIFORM PRODUCT, AND THAT EACH WELDING CONSUMABLE LISTED BELOW WAS FOUND IN COMPLIANCE WITH THE SPECIFICATION INDICATED AND IS ELIGIBLE TO BE PLACED ON THIS BUREAU'S APPROVED WELDING CONSUMABLES LIST IN THE SUBMERGED ARC WELDING SECTION

TRADE NAME	SPECIFICATION	GRADE OR CLASS	SHIELDING GAS	POSITION	CURRENT/ POLARITY	SIZE(MM)
T Union SA EM12K / T-UV620/T-UV101SJ	ABS	3YM	--	F	DCEP	Ø2.0, Ø2.5, Ø3.2 Ø4.0, Ø5.0
BOHLER SAW EMS 2 / BOHLER BB 622	ABS	3YM	--	F	DCEP	Ø2.0, Ø2.5, Ø3.2 Ø4.0, Ø5.0

NOTE
MULTIPLE NAME APPROVAL
WIRE: BOHLER SAW EMS 2 is identical to T Union SA EM12K
FLUX: BOHLER BB622 is identical to T-UV620/T-UV101SJ
WIRE: BOHLER SAW EMS 2 to be used together with Flux BOHLER BB 622 manufactured by Luoyang Peony Welding Material Group Co., Ltd.
WIRE: T Union SA EM12K to be used together with T-UV620/T-UV101SJ manufactured by Luoyang Peony Welding Material Group Co., Ltd.

Expiry Date: 25 June 2015

ABS SHANGHAI

An-Qing Fu SURVEYOR

Note: This Certificate evidences compliance with one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping and is issued solely for the use of the Bureau, its committees, its clients or other authorized entities. This Certificate is a representation only that the structure, item of material, equipment, machinery or any other item covered by this Certificate has met one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping as of the date of issue. Parties are advised to review the Rules for the scope and conditions of classification and to review the survey records for a fuller description of any limitations or limitation on the use of any item covered by this Certificate. This Certificate is governed by the Rules and standards of American Bureau of Shipping who shall remain the sole judge thereof. Nothing contained in this Certificate or in any instrument issued in connection with it shall be deemed to relieve any designer, builder, owner, manufacturer, seller, supplier, repairer, operator or other entity of any warranty express or implied.

WCM CERT Revision 3 Page 1 of 1

ISO9001：2008 CCS ABS

Wide Range Application

Peonyweld continues to provide excellent products and service to our customers.

Steel Construction	Pressure Vessel	Pipe Lines	Ship construction
Wind Energy	Gas cylinder	Boiler	Bridge construction
Aircraft Industry	Hardfacing	Nuclear Power	Box Girder






Submerged Arc Fluxes

Agglomerated Flux

- Can be made to any alloy or basicity requirement
- More versatile
- better at low currents < 600A
- better in high basicity compositions BI >2.5
- Better deep groove slag removal
- easier to feed in air feed systems
- lower weight consumption than fused
- usually less expensive

Fused Flux

- have better moisture resistance
- can be crushed to various mesh sizes
- better at very high currents
- can be recrushed and reused in overlay applications

Agglomerated Flux

- Alloy Steel
  - SJ101
  - SJ101G
  - SJ101T
  - SJ105
  - SJ206
  - SJ604

- Carbon Steel
  - SJ301
  - SJ501
  - NB501

- Stainless Steel
  - SJ303
  - SJ601

Peonyweld SJ101

Specifications

GB/12470-2003 F48A2-H10Mn2A
AWS A5.17/A5.23 F7A2-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
1.0	10-40mesh	Fluoride Basic	DC/AC

Feature
Stable arc
Easy slag removal
single pass circumferential welding

Application and advantage:
capable of welding low alloy steel
the most versatile flux
used in Steel structure Boiler Pressure vessel gas cylinder

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				-18℃	-29℃
EH14	495	415	28	/	68

Flux Composition

% SiO_2+% TiO2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
35-45	20-30	20-30	5-15	0.018%	0.052%

Peonyweld SJ101G

Specifications

GB/12470-2003 F48A4-H10Mn2 F48A2-H08MnA
AWS A5.17/A5.23 F7A4-EH14 F7A4-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
1.8	10-40mesh	Fluoride Basic	DC/AC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance
Higher impact value

Application and advantage:

capable of welding low alloy steel
Boiler Pressure vessel Pipeline
Used in multi-layer/pass also single
Especially used in dual-wire and single pass of large container

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				-29℃	-40℃
EM12K	540	465	31	110	70
EH14	590	495	28	/	98

Flux Composition

% SiO_2+%TiO2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
20-30	25-35	15-30	15-25	0.013%	0.038%

Peonyweld SJ101T

Specifications

GB/12470-2003 F48A4-EM12K
AWS A5.17/A5.23 F7A4-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
2.1	10-40mesh	Fluoride Basic	DC/AC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance
Higher impact value

Application and advantage:

capable of welding low alloy steel
Boiler Pressure vessel Pipeline steel structure
Used in multi-layer/pass also single
Especially used in dual-wire and single pass of large container

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)
				-40℃
EM12K	545	440	28	98

Flux Composition

% SiO_2+% TiO_2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
15-20	25-35	20-30	20-25	0.011%	0.043%

Peonyweld SJ301

Specifications

GB/T5293-1999 F4A2-H08A F7A2-H08MnA
AWS A5.17/A5.23 F7A0-EL8 F7A0-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
1.0	10-60mesh	Calcium-Silicate	DC/AC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance

Application and advantage:

With short slag,excellent used in small diameter circular welding general steel structure boiler pipeline
better Used in multi-layer/pass also single
While the wire connected with positive in DC,the most current is 1200A.
Used in large diameter pipe,getting smooth weld bead

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				0℃	-18℃
EL8	435	340	27	/	64
EM12K	545	425	24	80	85

Flux Composition

% SiO_2+%TiO2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
35-45	20-30	20-30	5-15	0.014%	0.051%

Peonyweld SJ303

Specifications
GB/T17854-1999、 NB/T47018-2011

Product information

Basicity Index	Grain size	Slag type	Polarity
1.1	20-80mesh	Calcium-Silicate	DC

Feature
Stable arc
Easy slag removal
Excellent weld deposit appearance

Application and advantage:
Combine With H00Cr21Ni10/H00Cr19Ni12Mo2 welding strips,excellent used in the corrosion resistant stainless steel surface welding
better Used in strip surfacing such as Chemical Reactor
While the strip connected with positive in DC, Used in hard facing welding, high efficiency and getting smooth weld bead

Flux Composition

% $Si0_{2}$+%TiO_{2}	% CaO+%MgO	% $Al_{2}O_{3}$+%MnO	% CaF	% S	% P
≈40	≈30	≈20	5-15	0.013%	0.025%

Peonyweld SJ501

Specifications

GB/T5293-1999 F4A0-H08MnA
AWS A5.17/A5.23 F7AZ-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
0.7	10-40mesh	Aluminum-Rutile	DC/AC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance
Insensitive to rust/scale/dirt

Application and advantage:

Active alloying acid flux,excellent used in tanks,pressure vessel,LPG cylinder,general steel structure boiler pipeline welding
better Used in multi wire high speed welding
While the wire connected with positive in DC,the most current is 1000A.
It features a smooth arc,good moisture tolerance.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				0℃	-18℃
EL8	435	330	24	50	/
EM12K	450	345	24	62	/

Flux Composition

% SiO_2+%TiO_2	% Al_2O_3+%MnO	% CaF	% S	% P
25-35	50-60	3-10	0.012%	0.025%

Peonyweld NB501

Specifications

GB/T5293-1999 F4A0-H08MnA
AWS A5.17/A5.23 F7AZ-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
0.7	10-40mesh	Aluminum-Rutile	DC/AC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance
Insensitive to rust/scale/dirt

Application and advantage:

Active alloying acid flux,excellent used in tanks,pressure vessel,LPG cylinder,general steel structure boiler pipeline welding
better Used in multi wire high speed welding
It features a smooth arc,good moisture tolerance.
Perfect for boiler welding.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				0℃	-18℃
EL12	435	330	24	50	/
EM12K	500	370	24	65	/

Flux Composition

% SiO_2+%TiO_2	% Al_2O_3+%MnO	% CaF	% S	% P
25-35	50-65	3-10	0.011%	0.025%

Peonyweld SJ105

Specifications

GB/T12470-2003、 NB/T47018-2011 F48A4
AWS.5.17/5.23 F7A4-EH14

Product information

Basicity Index	Grain size	Slag type	Polarity
2.2	10-60mesh	Fluoride-Basic	DC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance
High resistance to cracking

Application and advantage:

Specially hardfacing flux,excellent used in roll surfacing
better Used for DC power, especially rebuilding and surfacing of steel mill rolls
It features a smooth arc,and self-detaching slag even when the welding deposits is still hot.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				-29℃	-40℃
EH14	520	425	28	/	67

Flux Composition

% SiO_2+%TiO_2	% CaO+%MgO	% CaF	% Al_2O_3	% S	% P
18-22	33-37	25-30	10-20	0.011%	0.019%

Peonyweld SJ206

Specifications

GB/T12470-2003 F55A3-H09MnNiE
AWS A5.23 F8A2-ENi1K-Ni

Product information

Basicity Index	Grain size	Slag type	Polarity
1.1	10-40mesh	Aluminte-Basic	DC

Feature

Stable arc
Easy slag removal
Excellent weld deposit appearance

Application and advantage:

Single pass high speed welding, slow freezing slag, welding bead shape uniformity
suitable for various structural steel, high strength low alloy steel, and weathering steels making it widely used for pipe manufacturing.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				0℃	-29℃
ENi1K-Ni	580	495	20		55

Flux Composition

% SiO_2+%TiO2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
15-25	25-35	35-45	5-15	0.012%	0.036%

Peonyweld SJ601

Specifications

GB/T 17854-1999 NB/T47018-2011 F308-H08Cr21Ni10
AWS A5.9

Product information

Basicity Index	Grain size	Slag type	Polarity
1.8	10-40mesh	Fluoride-Basic	DC

Feature

pure weld deposit
low content of harmness

Application and advantage:

Single pass high speed welding, slow freezing slag, welding bead shape uniformity
suitable for various structural steel, high strength low alloy steel, and weathering steels making it widely used for pipe manufacturing.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)
				-196℃
H08Cr21Ni10	560	/	38	56

Flux Composition

% $Si0_{2}$+%TiO_{2}	% CaO+%MgO	% $Al_{2}O_{3}$+%MnO	% CaF	% S	% P
5-10	6-10	30-40	40-50	0.013%	0.035%

Peonyweld SJ604

Specifications

GB/T F48A6-ENi1 F48A5-EM12K
AWS F7A8-ENi1 F7A5-EM12K

Product information

Basicity Index	Grain size	Slag type	Polarity
2.8	10-40mesh	Fluoride-Basic	DC/AC

Feature

high Fluoride high basicity
excellent art properties
high purity of weld deposit

Application and advantage:

with different wire can be used in low-temperature steel and high strength steel like low-temperature pressure vessel,ocean platform,bridge construction
low diffusible hydrogen in weld deposit

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				-46℃	-60℃
ENi1	600	500	27		115
EM12K	565	475	29	96	

Flux Composition

% SiO_2+%TiO2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
15.52	33.04	22.02	22.94	0.015%	0.047%

Fused Flux

- HJ107
- HJ250
- HJ260
- HJ330
- HJ420
- HJ431
- DZH F600

Peonyweld HJ107

Specifications
GB/T GB/T 17854-1999 F308-H08Cr21Ni10

Product information

Basicity Index	Grain size	Slag type	Polarity
1.5	8-40mesh	Fluoride-Basic	DC

Feature
Medium Fluoride and Silicon
Free Manganese
shallow penetration
stable arc
easy slag removal

Application and advantage:
Welding Austenitic stainless steel,less carbon-pick-up and reducing burning of chromium
With stainless wire and strip,it is recommended for the overlaying and normal welding of the layer of corrosion resistant of petrochemical equipments,and also for High Manganese steel.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Elongtion(%)
H08Cr21Ni10	556	37

Deposited metal chemical component

GB F308-H08Cr21Ni10	C	Si	Mn	P	S	Cr	Ni
Actual(%)	0．068	0．85	1.36	0．025	0．013	18.92	9.93

Peonyweld HJ250

Specifications

GB/T 12470-2003 F48A2-H10Mn2
AWS A5.23 F7A0-EH14

Product information

Basicity Index	Grain size	Slag type	Polarity
1.6	10-40mesh	Fluoride-Basic	DC

Feature

low Manganese, medium silicon and Fluoride
With DC,stable arc easy slag removal

Application and advantage:

With suitable welding wire,EA4,EA3,it can be used for low alloy high strength steel.
Its impact value is good when welding cryogenic steel with H08Mn2MoVA.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)	
				0℃	-18℃
EH14	535	430	28		70

Flux Composition

% SiO_2	% CaO+%MgO	% $Al_2O_{3+\%MnO}$	% CaF	% FeO	% R_2O	% S	% P
18-22	21-29	26-32	20-24	≦1.5	≦3	≦0.06	≦0.08

Peonyweld HJ260

Specifications

GB/T 17854-1999 F308-H08Cr21Ni10

Product information

Basicity Index	Grain size	Slag type	Polarity
1.1	10-60mesh	Fluoride-Aluminum-Magnesiun	DC

Feature

low Manganese high silicon and Medium Fluoride
gray glassy grains
With DC,stable arc easy slag removal

Application and advantage:

With suitable stainless welding wire,H0Cr21Ni10,H0Cr21Ni10Ti,it is recommended for acis-resistant stainless steel structure and surfacing of steel roller

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Elongtion(%)
H08Cr21Ni10	540	36

Flux Composition

% $Si0_2$	% CaO+%MgO	% Al_2O_{3+}%MnO	% CaF	% FeO	% S	% P
29-34	19-25	21-28	20-25	≦1.0	≦0.06	≦0.08

Peonyweld HJ330

Specifications

GB/T 12470 F48A2-H10Mn2

AWS A5.23 F7A0-EH-14

Product information

Basicity Index	Grain size	Slag type	Polarity
1.0	8-40 mesh	Silicon-manganese	DC/AC

Feature

Easy salg removal

Excellent weld deposit appearance

Application and advantage:

Medium manganese high Silicon low Fluorite flux.

Used for low carbon steel and alloy steel structure/boiler/pressure vessel.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)
				-18℃
EH-14	530	425	27	73

Flux Composition

% SiO_2+%TiO_2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
44-48	18-23	26-30	3-6	0.06	0.08

Peonyweld HJ420

Specifications
GB/T 5293 F5A2-H10Mn2
AWS A5.17 F7A0-EH14

Product information

Basicity Index	Grain size	Slag type	Polarity
0.9	8-40 mesh 18-150mesh	Silicon-manganese	DC/AC

Feature
Easy salg removal
Excellent weld deposit appearance

Application and advantage:
High manganese and Silicon low Fluorite flux, good ability of anti rust and porosity.
Used for low alloy high strength steel structure/boiler/pressure vessel/ship building;
Fine mesh size can be used for thin plate single pass high speed welding.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)
				-18℃
EH-14	540	430	27	61

Flux Composition

% SiO_2	% TiO_2	%MnO	% S	% P
26-32	18-25	44-49	0.013	0.036

Peonyweld HJ431

Specifications
GB/T 5293 F4A2-H08A
AWS A5.17 F7A0-EL8

Product information

Basicity Index	Grain size	Slag type	Polarity
0.8	8-40 mesh	Silicon-manganese	DC/AC

Feature
Easy slag removal
Excellent weld deposit appearance

Application and advantage:
High manganese and Silicon low Fluorite flux.
Used for low carbon steel and low alloy steel structure/boiler/pressure vessel/ship building; also can be used for electroslag welding and Copper welding.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)
				-18℃
EL8	450	350	28	76

Flux Composition

% SiO_2+%TiO_2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
40-44	13-16	38-42	3-7	0.06	0.08

Peonyweld DZH F600

Specifications

GB/T5293-1999 F48A0-H10Mn2
AWS A5.17M-2007 F7AZ-EH14

Product information

Basicity Index	Grain size	Slag type	Polarity
1.0	30-150mesh	Silicon-manganese	DC/AC

Feature

Easy slag removal
Excellent weld deposit appearance

Application and advantage:

Fused flux specially used for electrosalg welding, combines low carbon steel and low alloy wires, especially for box girder structure application.

Typical Mechanical Properties

Wire	Tensile strength(Mpa)	Yield strength(Mpa)	Elongtion(%)	Impact Value(J)
				0℃
EH-14	520	415	27	62

Flux Composition

% SiO_2+% TiO_2	% CaO+%MgO	% Al_2O_3+%MnO	% CaF	% S	% P
40-45	15-20	25-30	5-10	0.016	0.052