

PREMIERWELD®AF-5

PRODUCT FEATURES

- Aluminate-Rutile type active agglomerated Flux
- Basicity Index: 0.8
- Grain Size: 10-60 Mesh
- Polarity: AC or DCEP

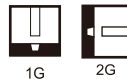
APPLICATION

- Thin plate single pass
- Applications without clean base material
- High speed welding, particularly those applications that require a very nice bead appearance

CONFORMANCE

- ASME SFA -5.17 AWS A5.17:F7AZ-EM12K
- ASME SFA-5.17M AWS A5.17M:F49A0-EM12K

WELDING POSITIONS



FLUX COMPOSITION (Wt-%) - TYPICAL

	SiO ₂ %	Al ₂ O ₃ %	Na ₂ O%	MgO%	MnO%	CaF ₂ %	P%	S%
PREMIERWELD®AF-5	24.0	27.8	1.9	16.5	8.9	8.8	0.035	0.018

WIRE & WELD DEPOSIT COMPOSITIONS (Wt-%) TYPICAL

	C%	Mn%	Si%	P%	S%
PREMIERWELD®AF-5/ PREMIERWELD®M12K	0.035	1.10	0.57	0.025	0.007

ALL WELD METAL MECHANICAL PROPERTIES - TYPICAL

Wire/Flux	Condition	Yield Strength KSi(MPa)	Tensile Strength KSi(MPa)	Elongation [%]	CVN-Toughness J @ 0°C
PREMIERWELD®AF-5/ PREMIERWELD®M12K	As-Welded	480	575	30	86

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

Authorized Distributor:

LINCOLN ELECTRIC[TANGSHAN]WELDING MATERIALS CO.,LTD

001,Riyuetan Road,Taiwan Industrial Zone,Luan County,Tangshan,Hebei Province,China 063700

TEL:+86 315 5038 500

FAX:+86 315 5038 503

www.lincolnelectric.com

