Company Reg # 2017/260076/07
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(A.W.S. F7A2-EM12K)

Basicity Index: 1.1

Description

DSE Submerged Flux is a neutral, semi-basic flux which, due to its low moisture content, is recommended for single and multi-pass welding on high tensile steels. It has good operating characteristics and is especially suited for use with small diameter alloyed wires in the build-up of crankshafts and other small diameter shafts. This flux can also be used with solid 300 series stainless steel wires. Due to its good slag detachability and relatively low alloying properties, DSE Submerged Flux can be used with S2 wires on low carbon steels where multi-pass welding (above 25mm thick material) needs to be done and where superior mechanical properties are required.

Typical Chemical Analysis of the Weld Metal (With Submerged S2 Wire)

Carbon	0.07
Silicon	0.611
Manganese	1.65
Sulphur	0.006

Typical Mechanical Properties of the Weld Metal (With Submerged S2 Wire)

Yield Stress (MPa)	391
Ultimate Tensile Strength (MPa)	475
Elongation (%)	22
Charpy V Notch (-18°C)	73

Packaging and Control

DSE Submerged Flux is manufactured in the grain sizes of 16 x 60 mesh and is packed in 25kg, multiple layer paper sacks with one layer that is plastic coated to act as a moisture repellent. All agglomerated fluxes should be stored in conditions of less than 70% relative humidity. Welding with damp flux can cause porosity. Re-drying of flux suspected of being moist should be done for approx. 2 hours at about 300°C at a flux depth of about 25mm.