



**ANAND MELT-1**  
Submerged  
Arc Welding Flux

## Description

### TECHNICAL DATA

ANAND MELT-1 is an agglomerated Flux designed for Submerged Arc Welding of mild, medium and high tensile steels in combination with ANAND SAW-1 (EL8) Grade wire, to yield weld metal with excellent chemical and mechanical properties. The slag removal is easy and weld metal has a smooth and shiny finish. Weld metal also of a radiographic quality.

## Typical Applications

ANAND MELT-1 Flux in a combination with ANAND SAW-1 Wire is suitable for welding mild, medium and high strength steels. Extensively used in welding of thick plates. S.A.W Pipes, Girders, off shore Platforms and Machines Building applications etc.

## Classifications

AWS/SFA 5.17 F7AZEL8

## Typical weld metal Analysis (%) When Used With ANAND SAW-1(EL8) Wire

C	Mn	Si	S	P
0.07	1.10	0.40	0.015	0.020

## Typical Weld Metal Mechanical Properties When Used With ANAND SAW-1 (EL8) Wire

UTS : 525 N/mm<sup>2</sup>  
YS : 425 N/mm<sup>2</sup>  
Elongation (%) (l-4xd) : 26.0  
CVN Impact : at RT 80 J

## Packing Specifications

Packed in Kraft Paper Bags with HDPE Lining from inside.

## Redrying Instructions

It is recommended to redry the Flux at 350°C for 2 hours before use for best results..

### **ANAND ARC LTD.**

#### **(AN ISO 9001 COMPANY)**

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### **ANAND ARC PRODUCTS**

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**ANAND MELT-2**  
Submerged  
Arc Welding Flux

### Description

### TECHNICAL DATA

ANAND MELT-2 is an agglomerated Flux designed for Submerged Arc Welding of mild, medium and high tensile steels in combination with ANAND SAW-2 (EH14) Grade wire, to give excellent mechanical properties and impacts down to L-20°C with extreme resistance to cracking. Owing to insensitivity to rust, scale, primer on the surface to be welded, has excellent x-ray characteristics and slag removal.

### Typical Applications

ANAND MELT-2 Flux in a combination with ANAND SAW-2 Wire is suitable for welding medium and high strength steel. Extensively used in welding of Pressure Vessels, Ships Building, Earthmoving Equipments, Machines Building Applications etc.

### Classifications

AWS/SFA 5.17 F7A2EH14

### Typical weld metal Analysis (%) When Used With ANAND SAW-2(EH14) Wire

C	Mn	Si	S	P
0.10	1.40	0.50	0.03	0.03

### Typical Weld Metal Mechanical Properties When Used With ANAND SAW-2 (Eh14) Wire

UTS : 530 N/mm<sup>2</sup>  
YS : 440 N/mm<sup>2</sup>  
Elongation (%) (l-4xd) : 27  
CVN Impact : 27 J at-20°C

### Packing Specifications

Packed in Kraft Paper Bags with HDPE Lining from inside.

### Redrying Instructions

It is recommended to redry the Flux at 350°C for 2 hours before use for best results..

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### **ANAND ARC PRODUCTS**

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**ANAND MELT-3**  
Submerged  
Arc Welding Flux

## Description

### TECHNICAL DATA

ANAND MELT-3 is an agglomerated aluminate rutile type flux. Relatively High Silicon pick up is achieved with the flux, when used with EL8 wire average Manganese pick up also results. ANAND MELT-3 enables the use of very high speed welding with twin, tandem, and multiwire technique. The weld metal is not susceptible to porosity when welded on work place contaminated by rust, scale etc. It is particularly resistant to arc burn through.

## Typical Applications

It is used for welding general Structural Steels, Pressure Vessels, Pipe Steels as well as Fine Grain Steels, Boiler Drums etc. On account of its good slag detachability ANAND MELT-3 is very commonly used for welding fillets. ANAND MELT-3 is particularly suited for pipe welding with high speeds. This Flux can be welded on AC or DC up 1000 Amps (with single wire process).

## General Classifications

Basicity Index 0.6  
Granulometry 10X150 B.S.S.

## Classifications

AWS/SFA F7AZEL8

## Typical weld metal Analysis (%) When Used With ANAND SAW-1(EL8) Wire

C	Mn	Si	S	P
0.070	1.30	0.45	0.018	0.018

## Typical Weld Metal Mechanical Properties When Used With ANAND SAW-1 (EL8) Wire

UTS : 560 N/mm<sup>2</sup>  
YS : 460 N/mm<sup>2</sup>  
Elongation (%) (l-4xd) : 25.0  
CVN Impact : at RT 80 J

## Packing Specifications

Packed in Polythene Lined Hassian Bags of 25/50 Kg. Net.

## Redrying Instructions

Flux should be kept dry. It is recommended to redry the Flux at 350°C for 2 hours before use for best results.

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**ANAND ARC**

**ANAND MELT-5**

Submerged  
Arc Welding Flux

**Description**

**TECHNICAL DATA**

ANAND MELT-5 is a basic aluminate type flux which has very good welding characteristics both in single and multi wire system. It is weldable on both AC & DC and can carry reasonably high currents. The flux being basic gives very low Hydrogen and Oxygen contents in weld metal and gives excellent impact values down to 40°C, - 50°C. The required weld metal strength is achieved by selection of suitable unalloyed (plain) and alloyed wires and the alloying elements are obtained mainly from the wire.

**General  
Classifications**

Basicity Index            1.6  
Granulometry            10X150 B.S.S.  
Current                    DC or AC

**Classifications**

AWS 5.17 F6A4EL8  
F7A4EM12K, F7A5EH14  
AWS 5.23 F11A4EG

**Typical Weld Metal  
Analysis (%)**

With Wire	C	Mn	Si	S	P	Cr	Ni	Mo
EL8	0.070	1.10	0.36	0.016	0.17	-	-	-
EM12K	0.082	1.40	0.38	0.017	0.16	-	-	-
EH14	0.100	1.50	0.40	0.017	0.16	-	-	-
EF5	0.090	1.60	0.36	0.016	0.16	0.60	2.30	0.50

**Typical Weld Metal  
Mechanical Properties**

With Wire	TS N/mm <sup>2</sup>	YS N/mm <sup>2</sup>	Elong (L=4xd)	CVN Impact in J		
				-30°C	-40°C	-50°C
EL8	440	370	29	-	60	-
EM12K	520	420	28	-	54	-
EH14	560	470	28	-	-	30
EF5	820	730	23	-	35	0

**Packing Specifications**

Packed in Kraft Paper Bags laminated from inside of 25 Kgs. Nett.

**Recommendations**

Flux should be kept dry. It is recommended to re-dry the Flux at 350°C for 2 hours before use for best results.

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**ANAND MELT-6**  
Submerged  
Arc Welding Flux

### Description

### TECHNICAL DATA

ANAND MELT-6 is an agglomerated Flux designed for submerged arc welding of medium and high tensile in combination with ANAND SAW-1 (EL8). Grade Wire ANAND SAW-3 (EM12K) wire to yield weld metal with excellent chemical and mechanical properties with respect with impact values down to 20°C. The slag removal is easy and weld metal has smooth and shiny finish, is also of radiographic quality.

### Typical Applications

ANAND MELT-6 Flux is combination with ANAND SAW-1 / ANAND SAW-3. Wire suitable for welding medium and high strength steels. Extensively used in welding of thick plates, S.A.W. Pipes. Grinders, Off Shore Platforms, Penstock Shells and Machine Building applications etc.

### Classifications

AWS : SFA 5.17 F7AOEL8/F7A2EM12K

Typical weld metal Analysis (%)  
When Used With  
ANAND SAW-1(EL8) Wire  
ANAND SAW-3 (EL12K) Wire

C	Mn	Si	S	P
0.07	1.40	0.40	0.015	0.020
0.08	1.70	0.50	0.018	0.018

Typical Weld Metal  
Mechanical Properties  
When Used with  
ANAND SAW-1 (EL8) Wire  
ANAND SAW-3 (EM12K) Wire

UTS N/mm <sup>2</sup>	YS N.mm <sup>2</sup>	EL(%) 1=4xd)	CVN Impact InJ
515	410	24	At -0°C 50
575	492	25	At -20°C 31

### Packing Specifications

Packed in Kraft Paper Bags with HDPE Lining from inside.

### Redrying Instructions

It is recommended to redry the Flux at 350°C for 2 hours before use for best results.

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### **ANAND ARC PRODUCTS**

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**ANAND MELT-03M**  
Submerged  
Arc Welding Flux

**Description**

**TECHNICAL DATA**

ANAND MELT-03M is basic type non-alloyed agglomerated flux for Submerged Arc Welding of Stainless Steel.

**Typical Applications**

It is ideal for butt & fillet welding at current upto 900 Amp on a single wire. Slag detachability is excellent leaving a good smooth, bright bead surface finish. Basicity level produces a low content of micro slag inclusions and ensures very good low temperature fracture toughness properties. Flux contains appropriate quantity of elements leads to good crack resistibility of weld metal having appropriate ferrite content.

**General Classifications**

Basicity Index                    1.80  
Granulometry                    12X100 B.S.S.  
Current                                DC or AC

**Chemical Composition (wt. %)**

With Wire	C	Cr	Ni	Mo	Nb
ER308L	<0.030	19.20	9.60	-	-
ER316	<0.06	18.60	11.10	2.20	-
ER316L	<0.03	19.00	11.30	2.30	-
ER347	<0.07	20.00	9.30	-	>8°C

**Typical Weld Metal Mechanical Properties**

Wire Grade AWS	Sr Status	% Elongation	Tenile Strength N.mm <sup>2</sup>	Charpy "V" Notch Impact Test Absobed Energy in Joules	Ferrite No.
ER308L	AW	34.0	520	>70 (20°C)	10-11
ER316	AW	30.0	560	>70 (20°C)	-
ER316L	AW	32.0	540	>70 (20°C)	-
ER347	AW	30.0	580	>65 (20°C)	-

**Packing Specifications**

Packed in Kraft Paper Bags with HDPE Lining from inside.  
Net. Wt. 25 Kgs.

**Redrying Instructions**

Flux should be kept dry. It is recommended to redry the Flux at 350°C for 1 hour before use for best results.

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**ANAND MELT-SS3**  
Submerged  
Arc Welding Flux

**Description**

**TECHNICAL DATA**

ANAND MELT-SS3 is basic type non-alloyed agglomerated flux for Submerged Arc Welding of Stainless Steel.

**Typical Applications**

It is ideal for butt & fillet welding at current upto 900 Amp on a single wire. Slag detachability is excellent leaving a good smooth, bright bead surface finish. Basicity level produces a low content of micro slag inclusions and ensures very good low temperature fracture toughness properties. Flux contains appropriate quantity of elements leads to good crack resistibility, good mechanical properties and good corrosion resistibility of weld metal having appropriate ferrite content.

**General Classifications**

Basicity Index                    1.40  
Granulometry                    12X100 B.S.S.  
Current                              DC or AC

**Chemical Composition (wt. %)**

With Wire	C	Cr	Ni	Mo
ER308L	<0.030	20.60	9.41	-
ER316	<0.06	18.60	11.00	2.60
ER316L	<0.03	19.20	11.15	2.60
ER347	<0.07	20.10	9.25	-

**Typical Weld Metal Mechanical Properties**

Wire Grade AWS	Sr Status	% Elongation	Tenile Strength N.mm <sup>2</sup>	Charpy "V" Notch Impact Test Absobed Energy in Joules	Ferrite No.
ER308L	AW	34.0	520	>70 (20°C)	12.-13
ER316	AW	30.0	560	>70 (20°C)	-
ER316L	AW	32.0	540	>70 (20°C)	-
ER347	AW	30.0	580	>65 (20°C)	-

**Packing Specifications**

Packed in Kraft Paper Bags with HDPE Lining from inside.  
Net. Wt. 25 Kgs.

**Redrying Instructions**

Flux should be kept dry. It is recommended to redry the Flux at 350°C for 1 hour before use for best results.

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**ANAND SAW-1**  
Copper Coated  
Solid Wire for  
SA Welding

**Description**

ANAND SAW-1 is a copper coated continuous solid wire for Submerged Arc Welding (SAW)

**Typical Applications**

It is ideally suited for continuous welding of Unalloyed, Mild and Medium Tensile Steels, in combination with agglomerated Submerged Arc Welding Fluxes. Finds application in the welding of continuously welded pipes, thicker steel sections, LPG cylinders etc.

**Classifications**

AWS/SFAA5.17 EL8

**Standard Wire  
Dia (mm)**

5.0, 4.0, 3.15, 2.5, 2.0 & 1.6

**Wire Analysis (%)**

C	Mn	Si	S	P	Cu
0.10 Max	0.25 - 0.60	0.07 Max	0.030 Max	0.030 Max	0.35 Max

**Packing Specifications**

Normally supplied as spools on Mild Steel Former with Nett. with 25 Kgs. wire can also supplied in steel bobbins & in sealed drums of approx. 500 kgs.

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## **ANAND SAW-2**

Copper Coated  
Solid Wire for  
SA Welding

### Description

ANAND SAW - 2 is a copper coated continuous solid wire for Submerged Arc Welding (SAW).

### Typical Applications

It is ideally suited for continuous welding of Medium and High Tensile Steels, In combination with agglomerated Submerged Arc Welding Fluxes. Finds application in the welding of LPG/LNG Storage Tanks, Low Temperature Service Equipments, Ships Building, Pressure Vessels etc.

### Classifications

AWS/SFA A5 17 EH14

### Standard Wire Dia (mm)

5.0, 4.0, 3.15, 2.5, 2.0 and 1.60

### Wire Analysis (%)

C	Mn	Si	S	P	Cu
0.10 - 0.20	1.70 - 2.20	0.10 Max	0.030 Max	0.030 Max	0.35 Max

### Packing Specifications

Normally supplied as spools on Mild Steel Former with Nett. wt. 25 Kgs. Wire can also supplied in sealed drums of approx. 500 kgs.

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**ANAND SAW-3**  
Copper Coated  
Solid Wire for  
SA Welding

**Description**

ANAND SAW - 3 is a copper coated continuous solid wire for Submerged Arc Welding (SAW)

**Typical Applications**

It is ideally suited for continuous welding of all range of thickness of plates in combination with agglomerated Submerged Arc Welding fluxes giving excellent impact properties and crack resistibility of welded metal. Finds application in the welding of single and multi layer welding of Structural Steels, Ships Building, Offshore Structures thick Pressure

**Classifications**

AWS/SFA A5.17 EM12K

**Standard Wire  
Dia (mm)**

5.0, 4.0, 3.15, 2.50

**Wire Analysis (%)**

C	Mn	Si	S	P	Cu
0.05 - 0.15	0.80 - 1.25	0.10 - 0.35	0.030 Max	0.030 Max	0.35 Max

**Packing Specifications**

Normally supplied as spools on Mild Steel Former with Nett. wt. 25 Kgs. Wire can also supplied in sealed drums of approx. 500 kgs.

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**ANAND ARC**

**ANAND SAW-7**  
Copper Coated  
Solid Wire for  
SA Welding

**Description**

ANAND SAW-7 is a copper coated continuous solid wire for Submerged Arc Welding (SAW)

**Typical Applications**

It is ideally suited for continuous welding of Non- alloyed Construction Steels, Boiler Plates, Fine Grained Steels, Ship Building Steels, Pipe Steels etc.

**Classifications**

AWS : SFA A 5.17 EH10K

**Standard Wire Dia (mm)**

5.0, 4.0, 3.15, 2.50

**Wire Analysis (%)**

C	Mn	Si	S	P	Cu
0.07 - 0.15	1.30 - 1.70	0.05 - 0.25	0.025 Max	0.025 Max	0.35 Max

**Packing Specifications**

Normally supplied as spools on Mild Steel Former with Nett. Wt. 25 Kgs.. Wire can also supplied in sealed drums of approx. 500 kgs.

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**ANAND ARC**

**ANAND SAW-8**  
Copper Coated  
Solid Wire for  
SA Welding

**Description**

ANAND SAW-8 is a Copper coated continuous solid wire for Submerged Arc Welding (SAW)

**Typical Applications**

It is a low carbon and low manganese general purpose wire for submerged arc welding. It is to be used with agglomerated submerged arc welding fluxes. It is suitable for single or multipass weld.

**Classifications**

AWS/SFA A5.17 EL12

**Standard Wire  
Dia (mm)**

5.0, 4.0, 3.15, 2.5, 2.0 AND 1.6

**Wire Analysis (%)**

C	Mn	Si	S	P	Cu
0.04 - 0.14	0.25 - 0.60	0.10 Max	0.030 Max	0.030 Max	0.35 Max

**Packing Specifications**

Normally supplied as spools on Mild Steel Former with Nett. Wt. 25 Kgs.. Wires can also supplied in sealed drums of approx. 500 kgs.

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