

# AS FX-N331



## Welding Flux for Un-alloyed and Low-Alloyed Steels

### Classification

**Flux/ Wire Combination**

AS FX-N331 / AS S2 (AWS A5.17: EM12K, EN 14171 : S2Si)

**AWS A5.17**

F7A0 -EM12K

### General Description

Silicon-calcium and neutral type agglomerated submerged arc welding flux. Used for welding of X42 and X46 grade pipes, boilers, off-shore and wind tower applications. It gives an excellent welding performance and bead appearance for high current welding applications. The weld metal has good mechanical properties with large heat input. Also ideal for welding of general and heavy structural steels performed with narrow weld groove in horizontal and flat positions . It is easy to remove the slag and should be re-dried at 300-350°C for 2 hours before use.

### Chemical Composition (w%) - Typical, All Weld Metal

Wire Grade	C	Mn	Si	S
AS S2Si	0.07	1.00	0.60	<0.025

### Mechanical Properties – Typical, All Weld Metal

Wire Grade	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact (Joule) 0 °C	
AS S2Si	After welding	423	515	27	110

### Materials to be Welded

	Standard	Material Type
<b>Ship Plates</b>		A-E
<b>General Structural Steels</b>	EN 10125	S185, S235, S275, S355
<b>Cast Steels</b>	EN 10213-2	GP240R
<b>Pipe Materials</b>	EN 10208-2 API 5LX	L210, L240, L290, L360 X42, X46
<b>Boiler and Pressure Vessel Steels</b>	EN 10216-1/ 10217-1	P235, P275, P355
<b>Fine Grained Steels</b>	EN 10218-1 EN 10025	P235GH, P265GH, P295GH, P355GH S275, S355

### Flux Characteristics

Current Type	: DC (+) / AC	Re-drying Temperature : 300 - 350 °C
Basicity (Boniszewski)	: 1.0	
Density	: 1.25 g/cm <sup>3</sup>	
Particule Size	: 10 - 40 Mesh	

### Packaging Detail

Packaging Type	Net weight (kg)
Bag	25

**Caution** : All product information given in this catalogue is prepared in line with the latest information available and may be revised and modified by Kaynak Tekniği Sanayi ve Ticaret A.Ş. without prior notice. The catalogue information serves as a product selection guide for welders. Refer to the classification of the relevant product to obtain mechanical values expected from the weld seam and filler metal.