

PREMIERWELD™ AF-5



CONFORMS TO

- AWS A5.17: F7A0-EL8, F7A0-EM12K

APPLICATION

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

PACKAGING

- 25 KG/Bag
- * Please contact your local Lincoln customer service for other type of packages.

PRODUCT INFORMATION

- Aluminate-Rutile type active agglomerated flux
- Basicity Index: 0.7
- Density: 1.25 g/cm³
- Grain Size: 10-60 Mesh
- Polarity: AC or DCEP

REDRYING

- Before welding, if moisture contamination is suspected from either improper storage condition or due to atmosphere exposure, the flux should be redried at 300 to 350°C for 2 hours.

FLUX COMPOSITION - TYPICAL

Al ₂ O ₃ +SiO ₂	MgO	MnO	CaF ₂	S	P
52.6%	16.5%	13.9%	6.3%	0.01%	0.03%

PREMIERWELD™ AF-5**CLASSIFICATION**

Flux / Wire	AWS A5.17
PREMIERWELD™ AF-5 / PREMIERWELD™ L8	F7A0-EL8
PREMIERWELD™ AF-5 / PREMIERWELD™ M12K	F7A0-EM12K

ALL WELD METAL CHEMICAL COMPOSITIONS (Wt -%) TYPICAL

Flux / Wire	C	Mn	Si	P	S
PREMIERWELD™ AF-5 / PREMIERWELD™ L8	0.07	1.12	0.82	0.032	0.016
PREMIERWELD™ AF-5 / PREMIERWELD™ M12K	0.07	1.37	0.91	0.032	0.019

ALL WELD METAL MECHANICAL PROPERTIES TYPICAL

Flux / Wire	Condition	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	CVN-Toughness (J) @ -17°C		
PREMIERWELD™ AF-5 / PREMIERWELD™ L8	As-Welded	440	530	31	63	76	58
PREMIERWELD™ AF-5 / PREMIERWELD™ M12K	As-Welded	520	600	30	88	96	73

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:

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