

Conformances: AWS A5.17 F7A2 EM12K
 AWS A5.23 EM12K

Approvals: ABS

Welding Process: SAW



FEATURES

- EM12K is general purpose SAW wire with low carbon, medium manganese and medium silicon wire which TS 35~100N/mm² higher than EL12 depending on flux and procedure.
- The EM12K copper coating yields significantly improved electrical contact between wire and contact tip for better arc stability and long tip life
- SWF 550 is a neutral flux for butt and fillet welding of carbon and low alloy steel. It can provide less flux consumption, excellent porosity resistibility and good slag remove.
- Flux 550 is suitable for single or multi-layer welding.

APPLICATIONS

- Sheffield EM12K/SWF 550 typical application is butt and fillet welding of vessels, shipbuilding, steel structures and general fabrication.

Typical Chemical Composition of Weld Metal

Element	C	Si	Mn	P	S
	0.052	0.33	1.50	0.01	0.01

Typical Mechanical Properties of Weld Metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Value (J) -20 deg. C
440	510	28	80