



# FEAT CRAFT HS1200m SUBMERGED ARC FLUX



**RECOMMENDED FOR AUTOMATIC AND SEMIAUTOMATIC SUBMERGED ARC WELDING**  
(Manufactured under quality system certified to ISO9001:2008)

## SPECIFICATION

**AWS : A5.17/ A5.23 F7A2-EM12K**

## DESCRIPTION

HS1200m is an agglomerated, Manganese Silicate flux for submerged arc welding. It is not sensitive to rust, scale, or primer paints so can be used in fillet welds, lap welds, and applications where base metal surfaces are not easily cleaned. Also suited to welding of square edge butt joints in thinner materials. With EL8 and EM12K wire, it is recommended for LPG gas cylinder, wheel hub, thin plate steel structures, and I beams.

## SPECIFICATION

BI	Density	Grain Size	Polarity
1.0	1.25g/cm <sup>3</sup>	10-60mesh	DCEP / AC

## FLUX COMPOSITION (Wt%)

COMPONENT	SiO <sub>2</sub> +TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	S	P	Metal alloys
CONTENT	20	35	25-30	15	≤0.025	≤0.03	≤2

## WELD DEPOSIT MECHANICAL PROPERTIES

Flux / Wire Combination	Tensile Strength (Mpa)	Yield Strength (Mpa)	Elongation (%)	Impact Value (J)	
				0°C	-29°C
EM12K	550	450	32	85	/
EH14	580	470	30	/	95



**Lincoln Energy Sdn Bhd (908445-A)**

No.13 and 15, Jalan BP 5, Bandar Bukit Puchong 47100 Puchong, Selangor Darul Ehsan.  
Tel: +603-8060 6131 Fax:+603-8060 6639 Email: sales@lincoln-energy.com