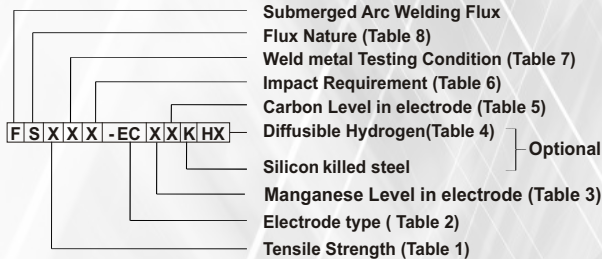


# CARBON STEEL CONSUMABLES & FLUXES CLASSIFICATION FOR SAW (AWS A/SFA 5.17)



**Table 1: Tensile Strength of undiluted weld metal**

Code Digit	Tensile Strength psi (MPa)
6	60,000-80,000 (430-560)
7	70,000-90,000 (480-660)

**Table 2: Electrode Type**

Code Digit	Type
E	Solid Electrode
EC	Composite

**Table 3: Manganese Level in wire**

Code Digit	Manganese Level Approx. (%)
L	0.25-0.60
M	0.80-1.50
H	1.30-2.20

**Table 4: Diffusible Hydrogen**

Code Digit	Diffusible Hydrogen Content, average (ml/100g deposited metal), max
H2	2
H4	4
H8	8
H16	16

**Table 5: Carbon Level in wire**

Code Digit	Average Carbon level (%)
8	0.08
10	0.1
11	0.11
12	0.12
13	0.13
14	0.14
15	0.15

**Table 6: Impact Requirement for weld metal**

Code Digit	Maximum Test Temperature (°F)	Maximum Test Temperature (°C)	Minimum Avg value (J)
0	0	0	27
2	-20	-20	
3	Not Specified	-30	
4	-40	-40	
5	-50	-50	
6	-60	-60	
8	-80	Not Specified	
Z	No Impact Requirement		

**Table 7: Weld Metal Testing Condition**

Code Digit	Testing Condition
A	As-Welded
P	Post Weld Heat treated

**Table 8: Flux Nature**

Code Digit	Flux Nature
S	Crushed Slag or blend of crushed slag with unused flux (Virgin flux)
omission of 'S'	Virgin flux



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