

**Characteristics and Applications:**

HOBART HA-495 is an agglomerated aluminate-rutile flux with pick up of Mn and Si. Suitable for welding with single and multiple wire process with AC as well DC. Has excellent bead appearance, resistant against porosity and excellent slag detachability.

- Shipbuilding
- Structural steels
- LPG cylinders

**Notes on Usage:**

1. The flux must be re-dried at a temperature of 300~350°C for 1~2hr holding time when it is affected by moisture pick-up.
2. Adding proper quantity of new flux with the used one to maintain good quality of weld metal.

**Typical Chemical Composition of Weld Metal (wt %)**

Wire	Weld metal classification		C	Si	Mn	P	S	Mo
	AWS A5.17	EN ISO 14171-A						
HOBART L12	F7AZ-EL12	S 38 Z AR S1	0.05	0.5	1.1	<0.03	<0.02	-
HOBART M12K	F7A0-EM12K	S 38 0 AR S2Si	0.06	0.7	1.7	0.035	0.012	-
HOBART H12K	F7A2-EH12K	S 46 2 AR S3Si	0.06	0.7	1.8	0.03	0.01	-
Wire	Weld metal classification		C	Si	Mn	P	S	Mo
	AWS A5.23	EN ISO 14171-A						
HOBART 12E	F9AZ-EA2-G	S 50 Z AR S2Mo	0.05	0.7	1.5	0.03	0.012	0.43

**Typical Mechanical Properties of Weld Metal**

Wire	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C(°F)	Remark
HOBART L12	460(67)	540(78)	32	-	-	--
HOBART M12K	480(70)	550(80)	33	40(30)	-20(0)	AW
HOBART H12K	529(77)	589(85)	30	43(32)	-30(-20)	AW
HOBART 12E	617(89)	656(95)	29	-	-	AW

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