



# ESAB 81PB

An agglomerated flux for Submerged Arc Welding of non-alloyed steels.

## Classifications

AWS A5.17: F7AZ-EL8/EL12  
F7AZ-EM12K



## Description

ESAB 81PB is an agglomerated submerged arc welding flux designed for fillet and butt welding of non-alloyed steels. Its unique design delivers good welding characteristics. It provides uniform welds with good slag release and weld bead appearance. With its Mn & Si alloying design, the flux is best suited for high speed welding for limited number of passes.

Typical All Weld Metal Properties	ESAB 81PB /	
	OK Autrod 12.08L	OK Autrod 12.22L
C	0.06	0.06
Mn	0.90	1.30
Si	0.45	0.60
P	0.03	0.03
S	0.02	0.02
YS (MPa)	420	460
UTS (MPa)	500	530
Elongation (%)	30	30

## Applications

- General fabrication
- Beams fabrication

## Features

- Uniform welds
- Good slag release
- Good weld bead appearance

## Registered and Head Office: ESAB India Limited

13, 3rd Main Road, Industrial Estate,  
Ambattur, Chennai - 600 058.  
Tel: +91(0) 44 4228 1100, Fax: +91(0) 44 4228 1150  
Email: info@esab.co.in | www.esabindia.com



www.esab.com



2021-11-18 / ESAB reserves the right to alter specifications without prior notice.