



Maxflux SAF-4 (UV)

Agglomerated flux for Submerged Arc Welding.



CODIFICATION: AWS A5.17: F7A4/ P4-EH14, F7A5/ P5-EH10K
 AWS A5.23: F8A4/ P4-EA2-A2 & EA3-A3, F9A4/ P2-EF3-F3, F10A4/ F9P5-EM-4-M4

CHARACTERISTICS: Maxflux SAF-4 (UV) is an agglomerated fluoride basic flux suitable to weld medium to high strength steels & low alloy steels. The weld made with this flux gives very low diffusible hydrogen content, good crack resistance and high sub-zero toughness properties. The flux provides uniform fusion in fillet welds & butt welds with excellent slag detachability. The flux can be used for multi-pass welding. The deposits are of radiographic quality and have less than 4ml diffusible hydrogen/ 100gms of weld metal.

APPLICATIONS: Maxflux SAF-4 (UV) is suitable for single & multilayer welding of various structural, Boiler, Pressure vessel steels, Petrochemical industries, Refineries, Shipping, Quenched & tempered steel, heat resistant steels, Nuclear sector fabrications & other fabrication industries.

CHEMISTRY OF WIRE/ WELD METAL, (WT. %):

Details	AWS class	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Autotherme Gr-C (wire)	EH-14	0.1-0.2	1.7-2.2	0.1	0.03	0.03	-	-	-	0.35
Autotherme Gr-E (wire)	EH-10K	0.07-0.15	1.3-1.7	0.05-0.25	0.025	0.025	-	-	-	0.35
Autotherme Grade-F	EA-2	0.12	1.4	0.8	0.03	0.03	-	-	0.4-0.65	0.35
Autotherme Grade-U	EA-3	0.15	2.1	0.8	0.03	0.03	-	-	0.4-0.65	0.35
Autotherme Grade-P	EF-3	0.17	1.25-2.25	0.8	0.03	0.03	-	0.7-1.1	0.4-0.65	0.35
Autotherme Grade-Q	EM-4	0.1	1.3-2.25	0.8	0.02	0.02	0.8	2.0-2.8	0.3-0.8	0.30

MECHANICAL PROPERTIES:

Details	PWHT	UTS (MPa)	0.2 % YS (MPa)	% EL (L=4d)	CVN Impact at °C (J)		
					-29°C	-40°C	-46°C
Autotherme Grade-C	As-weld	582	494	23	-	120	-
Autotherme Grade-C	620°C for 1hr	536	453	32	-	132	-
Autotherme Grade-E	As-weld	570	484	30	-	110	72
Autotherme Grade-E	620°C for 1hr	537	463	31	-	148	68
Autotherme Grade-F	As-weld	612	535	30	-	105	-
Autotherme Grade-F	620°C for 1hr	594	482	31	-	126	-
Autotherme Grade-U	As-weld	612	510	27	-	134	-
Autotherme Grade-U	620°C for 1hr	597	477	37	-	142	-
Autotherme Grade-P	As-weld	675	535	28	-	120	-
Autotherme Grade-P	620°C for 1hr	660	554	28	46	-	-
Autotherme Grade-Q	As-weld	793	665	20	-	62	-
Autotherme Grade-Q	590°C for 3hrs	777	675	20	-	78	58

GRAIN SIZE: 0.15-1.6 mm

PACKAGING: 25 kg Poly-lined paper bag

RE-DRYING CONDITIONS: 350°C for 2 hours

An ISO 9001: 2008 certified company

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