



Maxflux HF - 250

Agglomerated hard-surfacing flux for
Submerged Arc Welding



CHARACTERISTICS:

Maxflux HF-250 is a hard surfacing type flux suitable for moderate abrasion resistance applications in combination with EL-8 grade (Autotherme Grade A) wire. Slag removal is easy and weld bead is smooth & shiny. The deposited weld metal is of radiographic quality.

APPLICATIONS:

Maxflux HF-250 is suitable for surfacing of tractor rollers, excavator parts, tracks lines, crane wheels, etc.

ALL-WELD ANALYSIS, WT %:

Autotherme Grade A (Gr: EL-8)

C	Mn	Si	Cr	Mo	Cu
0.12	0.9	0.65	2.1	0.15	0.15

ALL-WELD METAL HARDNESS (AS- WELD):

Autotherme Grade A (Gr: EL-8)

Hardness on MS plate - 1 st layer	Hardness on MS plate - 2 nd layer	Hardness on MS plate - 3 rd layer
-	240-260 BHN	240-270 BHN

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
25%	5%	50%	25%

BASICITY INDEX : ~0.7

GRAIN SIZE : 0.40 – 2.0 mm

PACKAGING : 25 kgs poly-lined paper bag

RE-DRYING CONDITIONS : 300°-350°C for 2 hours

An ISO 9001: 2008 COMPANY

D&H Sécheron Electrodes Private Limited

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