Maxflux LAB-223

Agglomerated Basic flux for Multi Wire Submerged Arc Welding

CODIFICATION: AWS SFA 5.17/ 5.23 F7A2/A4EM-12K, F7A2/A4EH-14

CHARACTERISTICS: Maxflux LAB-223 is a basic type flux for high speed longitudinal welding giving smooth & shiny weld bead along with easy slag removal characteristics. The flux is suitable for multi-wire submerged arc welding applications and supports to achieve higher throat thickness in welding of fillet joints due to higher current carrying capacity.

APPLICATIONS: Maxflux LAB-223 is suitable for both single & multi-layer welding of structural steels, boiler & pressure vessel quality steels and other fabrication involving medium tensile & low alloy steel.

ALL-WELD ANALYSIS, WT %:

	C	Mn	Si	S	P
Autotherme Grade B	0.07	1.10	0.25	0.022	0.025
Autotherme Grade C	0.09	1.45	0.42	0.021	0.023

ALL-WELD MECHANICAL PROPERTIES:

	UTS (MPa)	0.2% YS (MPa)	%EL (L=4d)	CVN Impact (J) at	
				-29°C	-40°C
Autotherme Grade B	510	440	30	78	45
Autotherme Grade C	560	505	28	80	66

MAJOR CONSTITUENTS:

$SiO_2 + TiO_2$	CaO + MgO	$Al_2O_3 + MnO$	CAF_2
10%	40%	30%	20%

BASICITY INDEX: ~1.6

GRAIN SIZE: 0.30 – 1.60 mm

PACKAGING: 25 kgs poly-lined paper bag

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

An ISO 9001: 2008 COMPANY

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