



# Maxflux SAF-11



Agglomerated Flux for Submerged Arc Welding

**CODIFICATION:** AWS: SFA 5.23 F8A2EG-G

**CHARACTERISTICS:** Maxflux SAF- 11 special flux to weld 0.5Cr-0.7Ni-0.5Cu Weathering steels. The weld metal produces smooth beads and good slag detachability. The weld metal gives very less diffusible hydrogen (<5 ml/100gms. of W.M.).

**APPLICATIONS:** Maxflux SAF-11 is suitable for single & multilayer welding of various weathering steels. Especially suitable for welding of Corten steels used in chemical, Petrochemicals and railway industries to resist atmospheric corrosion like ASTM steels: Grade ASTM A588Gr.A, B or C & A709 Gr.50W etc.

**ALL-WELD ANALYSIS, WT %:**

Autotherme Grade -G

Element	C	Mn	Si	S	P	Cr	Ni	Cu
Range	0.12 Max	0.50- 1.30	0.35- 0.80	0.030 Max	0.030 Max	0.45- 0.70	0.40- 0.80	0.30- 0.75
Typical	0.06	0.72	0.47	0.016	0.022	0.56	0.72	0.50

**ALL-WELD MECHANICAL PROPERTIES**

Autotherme Grade-G:

As Welded

	UTS (MPa)	0.2% YS ( MPa)	%EL (L=4d)	CVN Impact, (J) at -20°C
Typical	570	480	24	45

**BASICITY INDEX :** ~1.8

**GRAIN SIZE :** 0.35 – 1.60 mm

**PACKAGING:** 25 kgs poly-lined paper bag

**RE-DRYING CONDITION:** 300°-350°C for 2 hours

**An ISO 9001: 2008 COMPANY**

**D&H Sécheron Electrodes Private Limited**

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