



Maxflux SAF -12

Agglomerated flux for Submerged Arc Welding.



CODIFICATION: AWS A5.23 / F8P2-EB6-B6, F8P2-EB2R B2, F9 P2-EB3R B3, F9PZEB9-B9

CHARACTERISTICS: Maxflux SAF-12 is a special flux used to weld creep resistant steels. The weld metal possesses good CVN toughness combined with good strength. The weld metal produces smooth beads, good wetting, and excellent slag detachability. The weld metal gives very less diffusible hydrogen (<5 ml/100gms. of W.M.).

APPLICATIONS: Maxflux SAF- 12 is suitable for single & multilayer welding of various structural, Boiler, Pressure vessel steels, Petrochemical industries, Refineries & other fabrication steels. It is suitable for welding of ASTM steels: Grade ASTM A213Gr.T5 A335 Gr.P5, A217 Gr.C5, A387 Gr11 & 12, A182 F11 & F12, A217 WC6 & WC11, A234 WP11 & WP12 A199 T11, A387 Gr 21 & 22 A234 WP22 A199 T21, T22 A200 T21, T22 A213 T22A335 P22, A 213 T91, A 335 P91, A 387 Gr 91, A 182 / A336, A 217 C12A, A 234 WP91, A 369 FP91 etc.

TYPICAL ALL WELD CHEMICAL ANALYSIS, WT. %:

Details	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V	Nb	N	Al
Autotherme Gr.-R	0.08	0.80	0.32	0.013	0.017	5.30	-	0.52	0.11	-	-	-	-
Autotherme Gr.-LR	0.07	0.71	0.32	0.009	0.009	1.21	-	0.52	0.13	-	-	-	-
Autotherme Gr.-MR	0.07	0.73	0.31	0.009	0.009	2.21	-	1.10	0.11	-	-	-	-
Autotherme Gr.-N	0.10	0.90	0.25	0.009	0.009	9.5	0.4	1.0	0.01	0.2	0.04	0.04	0.02

MECHANICAL PROPERTIES OF ALL WELD METAL

Details	PWHT	UTS (MPa)	0.2 % YS (MPa)	% EL. (L=4d)	CVN Impact (J)		
					+20°C	-20°C	-29°C
Autotherme Gr.-R	745°C for 1hr.	655.0	548.0	21.0	-	32	-
Autotherme Gr.-LR	690°C for 1hr.	580.0	490.0	23.0	-	-	65
Autotherme Gr.-MR	690°C for 1hr.	640.0	570.0	22	-	-	70
Autotherme Gr.-N	760°C for 2hr.	680.0	575.0	21.0	54	-	-

- BASICITY INDEX** : ~3.1
- GRAIN SIZE** : 0.35-1.6 mm
- PACKAGING** : 25 kg poly-lined paper bag
- RE-DRYING CONDITIONS** : 300-350°C for 2 hours

An ISO 9001: 2008 certified company
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