
 D&H sécheron Complete Welding Support	<h1>Maxflux SAF -13</h1>	
	Agglomerated flux for Submerged Arc Welding	

CODIFICATION: **AWS A5.23 / F8P0-EB2-B2, F9P0-EB3-B3**

CHARACTERISTICS: Maxflux SAF-13 is a special flux used to weld structural steels. The Flux is specially designed to meet the tensile strength & Impact requirements. The weld metal produces smooth beads, good wetting, and excellent slag detachability. The weld metal gives very less diffusible hydrogen (<5 ml/100 gms. of W.M.).

APPLICATIONS: Maxflux SAF- 13 is suitable for single & multilayer welding of various structural, Boiler, Pressure vessel steels & other fabrication steels. It is suitable for welding of ASTM steels: A387 Gr 11, 12, A182 F11, F12, A217 WC6,WC11, A234 WP11, WP12, A199 T11 ASTM A387 Gr 21, 22 A234 WP22 A199 T21, T22 A200 T21, T22 & A213 T22A335 P22, etc.

ALL- WELD ANALYSIS, WT. %:

Details		C	Mn	Si	S	P	Cr	Mo	Cu
With Autotherme Grade - L	Range	0.05 - 0.15	1.20 Max	0.80 Max	0.030 Max	0.030 Max	1.0-1.50	0.40-0.65	0.35 Max
	Typical	0.08	0.90	0.50	0.010	0.015	1.20	0.50	0.12
With Autotherme Grade - M	Range	0.05-0.15	1.20 Max	0.80 Max	0.030 Max	0.030 Max	2.0-2.50	0.90-1.20	0.35 Max
	Typical	0.08	0.70	0.60	0.010	0.015	2.40	1.10	0.13

MECHANICAL PROPERTIES OF ALL WELD METAL

Details	PWHT	UTS (MPa)	0.2 % YS (MPa)	% EL. (L=4d)	Impact CVN (J) -18°C	Hardness (VPN)
Autotherme Grade- L	690°C for 1 hr	630	550	24	60	180
Autotherme Grade- M	690°C for 1 hr	650	570	22	70	190

BASICITY INDEX : 3.0-3.4
GRAIN SIZE : 0.35-1.6 mm
PACKAGING : 25 Kg poly-lined paper bag
RE-DRYING CONDITIONS : 300-350°C for 2 hours.

<p>An ISO 9001: 2008 certified company</p> <p>D&H Sécheron Electrodes Private Limited</p> <p>44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260 E-mail: tsd@dhsecheron.net Website: www.dnhsecheron.com</p> <p style="text-align: right;">JUN. 2017 (Rev.: 06)</p>
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