



# Maxflux SAF-2

Agglomerated Acidic Flux for Submerged Arc Welding



**CODIFICATION:**

AWS: SFA 5.17 F7AZEL-8, F7A0EM-12K

**CHARACTERISTICS:**

Maxflux SAF-2 is an alumina-rutile type acidic flux to weld medium tensile structural steels. The slag is easily removable and bead finish is smooth & shiny. Weld deposit is of radiographic quality.

**APPLICATIONS:**

Maxflux SAF-2 is suitable for single and multi layer welding of various structural & pressure vessel steels like; IS:2062, Gr.516 Gr.60, ASTM A285 Gr. C, ASTM A-36, BS:1501-151 Gr.400, machine building and fabrication of earthmoving equipment, crane girders, ships, locomotives, etc.

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

	C	Mn	Si	S	P	Cu
Autotherme Grade A	0.05	1.10	0.35	0.027	0.028	0.15
Autotherme Grade B	0.07	1.25	0.50	0.028	0.026	0.15

**ALL-WELD MECHANICAL PROPERTIES:**

	0.2% YS MPa	UTS MPa	EL (L=4d) %	Impact, J at		
				RT	0°C	-20°C
Autotherme Grade A	410	500	26	55	30	–
Autotherme Grade B	418	510	25	60	40	30

**MAJOR CONSTITUENTS:**

SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CAF <sub>2</sub>
25%	5%	50%	25%

**BASICITY INDEX** : ~0.7

**GRAIN SIZE** : 0.35 – 1.60 mm

**PACKAGING** : 25 kg. 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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