



Maxflux SAF-223(Mod)

Agglomerated Basic flux for Submerged Arc Welding



CODIFICATION:

AWS SFA 5.17/ 5.23 F7A5EH-14, F7A5EM-12K, F8A4EA2-A2

CHARACTERISTICS:

Maxflux SAF-223 (Mod) is a basic type flux for high speed welding of longitudinal pipe giving smooth & shiny weld bead with improved impact toughness properties. The flux is also 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 SAF-223 (Mod) is suitable for single & multi-layer welding of pressure vessel grade steels (EN 10028-2), X-42 to X-70 grade pipes conforming to API-5L specification, etc.

ALL-WELD ANALYSIS, WT %:

| | C | Mn | Si | S | P | Mo |
|--------------------|----------|-----------|-----------|----------|----------|-----------|
| Autotherme Grade B | 0.065 | 1.55 | 0.52 | 0.017 | 0.025 | - |
| Autotherme Grade C | 0.10 | 1.40 | 0.38 | 0.020 | 0.023 | - |
| Autotherme Grade F | 0.07 | 1.31 | 0.59 | 0.018 | 0.022 | 0.47 |

ALL-WELD MECHANICAL PROPERTIES:

| | UTS (MPa) | 0.2% YS (MPa) | %EL (L=4d) | CVN Impact (J) at | | |
|--------------------|--------------|------------------|---------------|-------------------|-------|-------|
| | | | | -29°C | -40°C | -46°C |
| Autotherme Grade B | 550 | 455 | 27 | - | - | 60 |
| Autotherme Grade C | 572 | 460 | 26 | 80 | 60 | 40 |
| Autotherme Grade F | 630 | 570 | 25 | 50 | 40 | - |

MAJOR CONSTITUENTS:

| SiO ₂ + TiO ₂ | CaO + MgO | Al ₂ O ₃ + MnO | CAF ₂ |
|-------------------------------------|-----------|--------------------------------------|------------------|
| 10% | 40% | 30% | 20% |

BASICITY INDEX:

~1.6

GRAIN SIZE:

0.20 – 1.50 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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