



# Maxflux SAF-223

Agglomerated basic flux for Submerged Arc Welding



**CODIFICATION:**

AWS: SFA 5.17/ 5.23 F7A4EH-14, F7A4EM-12K, F8A2EA2-A2

**CHARACTERISTICS:**

Maxflux SAF-223 is a basic type flux for high-speed longitudinal welding giving smooth & shiny weld bead along with easy slag removal characteristics. 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 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	Cu
Autotherme Grade B	0.07	1.00	0.25	0.022	0.025	–	0.15
Autotherme Grade C	0.10	1.40	0.38	0.020	0.023	–	0.15
Autotherme Grade F	0.07	1.38	0.59	0.018	0.022	0.47	0.15

**ALL-WELD MECHANICAL PROPERTIES:**

	UTS (MPa)	0.2% YS (MPa)	%EL (L=4d)	CVN Impact, J at	
				-29°C	-40°C
Autotherme Grade B	510	440	30	78	45
Autotherme Grade C	580	505	28	80	50
Autotherme Grade F	620	530	27	85	–

**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>
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**

**D&H Sécheron Electrodes Private Limited**

44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260  
E-mail: tsd@dnhsecheron.net Website: www.dnhsecheron.com

JUN 2017 (Rev.: 04)