

	<h1>Maxflux SAF-231</h1>	
	<p>Agglomerated flux for Submerged Arc Welding.</p>	

CODIFICATION: **AWS A5.23: F8P2-EB2/ EB2R-H8**

CHARACTERISTICS: Maxflux SAF-231 is an agglomerated special flux used for fillet & butt-welding of carbon steel and Cr-Mo steel plates. The active nature of the flux provides an outstanding tolerance to rust, mill scale, etc so that joint preparation during welding is minimized. The superior fusion properties of the flux provide uniform fusion in fillet welds with excellent slag detachability. The flux can also be used for multi-pass welding but shall be restricted to 25mm thickness as it is active in nature. The deposited weld metal is of radiographic quality and the diffusible hydrogen content is <5 ml/100gm of weld metal.

APPLICATIONS: Maxflux SAF- 231 is suitable for single & multilayer welding of various structural, Boiler, Pressure vessel steels, Petrochemical industries, Refineries, Shipping & other fabrication industries.

CHEMISTRY, (WT. %):

Details	C	Mn	Si	S	P	Cr	Mo	Cu	As	Sb	Sn
Requirement-AWS EB2 class	0.05-0.15	0.45-1.0	0.05-0.30	0.025 max	0.025 max	1.0-1.75	0.45-0.65	0.35 max	-	-	-
Autotherme Grade-L/ LR	0.11	0.84	0.14	0.004	0.003	1.18	0.48	0.16	<0.005	<0.005	<0.005

MECHANICAL PROPERTIES:

Details	PWHT (as per AWS)	UTS (MPa)	0.2 % YS (MPa)	% EL (L=4d)	CVN Impact (J) at	
					-20°C	-29°C
Requirements for B2 class	690°C for 1hr	550-700	470 min	20.0 min	-	27
Maxflux SAF-231 & Autotherme Grade-L	690°C for 1hr	640.0	535.0	22.0	38	34

GRAIN SIZE : 0.15-1.6 mm

PACKAGING : 25 kg Poly-lined paper bag

RE-DRYING CONDITIONS : 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</p> <p>E-mail: info@dnhsecheron.net Website: www.dnhsecheron.com</p>	<p>JUN 2017 (Rev.: 01)</p>
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