

CODIFICATION: AWS: SFA 5.17 F7A0EL8, F7A0EM12K

CHARACTERISTICS: Maxflux SAF-3 is an alumina-rutile type acidic flux to weld medium tensile structural steels. The slag is easy to remove and the weld deposit is of radiographic quality.

APPLICATIONS: Maxflux SAF-3 is suited for fabrication and welding of penstock pipelines, pressure vessels, earthmoving equipment, off-shore platforms, boilers, rail & crane girders, machine building, locomotive works, etc.

ALL-WELD ANALYSIS, WT %:

	C	Mn	Si	S	P	Cu
Autotherme Grade A	0.05	1.20	0.45	0.027	0.028	0.15
Autotherme Grade B	0.07	1.35	0.50	0.028	0.026	0.15

ALL-WELD MECHANICAL PROPERTIES:

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

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
20%	10%	45%	25%

BASICITY INDEX : ~0.7

GRAIN SIZE : 0.35 – 1.60 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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