
	Maxflux SAF- 4	
	Agglomerated Basic Flux for Submerged Arc Welding	

CODIFICATION: AWS: SFA 5.17 F6A2-EL8, F7A2-EM12K, F7A4-EM12K, F7A4-EH14

CHARACTERISTICS: Maxflux SAF-4 is a basic type flux having very good performance with good sub-zero impact properties & extreme resistance to cracking. It is neutral in terms of silicon and manganese pick-up. Slag is easily removable and bead finish is smooth & shiny. The diffusible hydrogen content of the weld metal is low.

APPLICATIONS: Maxflux SAF-4 is suitable for single & multi-layer welding of structural steels, pressure vessels, boilers and other fabrications involving medium tensile & low alloy steel.

ALL-WELD ANALYSIS, WT %:

	C	Mn	Si	S	P	Cu
Autotherme Grade A	0.05	0.60	0.30	0.028	0.027	0.15
Autotherme Grade B	0.06	1.00	0.35	0.028	0.026	0.15
Autotherme Grade C	0.06	1.50	0.38	0.028	0.027	0.15

ALL-WELD MECHANICAL PROPERTIES:

	0.2% YS MPa	UTS MPa	EL (L=4d) %	Impact, J at		
				-18°C	-29°C	-40°C
Autotherme Grade A	380	460	26	40	30	–
Autotherme Grade B	415	510	25	70	60	34
Autotherme Grade C	418	530	26	90	75	45

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
20%	25%	20%	35%

BASICITY INDEX : ~1.6

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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