



Maxflux SAF-42

Agglomerated hard surfacing flux for
Submerged Arc Welding



CHARACTERISTICS:

Maxflux SAF-42 is a hard-surfacing flux for re-building of rolls of base materials as per EN -10269: 16CrMo4, 25CrMo4, 42CrMo4 specification or their near equivalent grades. The hardness of the weld metal deposited with Autotherme CR-10 wire after stress relief heat treatment ranges between 40-44 HRC and has excellent metal to metal wear resistance. Slag removal is easy and weld bead is smooth & shiny. The deposited weld metal is of radiographic quality.

APPLICATIONS:

Maxflux SAF-42 flux and Autotherme Cr-10 wire combination is suitable for surfacing under moderate temperature, high compressive pressure and metal to metal wear between the job & the rolls.

ALL-WELD ANALYSIS, WT %:

Autotherme Cr-10

C	Mn	Si	Cr	Mo
0.10-0.25	0.5-1.5	1.0 max	11.0-13.0	0.50 max

WELDING CARE & PRECAUTIONS:

1. Pre-cleaning of the rolls to weld-worthy conditions.
2. Stress relieving of the worn out rolls prior to welding.
3. Pre-heating & inter-pass temperature of the rolls to 250°C.
4. The heating & cooling rate during post-weld stress relieving (SR) shall be controlled to 100°C per hour.

ALL-WELD METAL HARDNESS:

Autotherme Cr-10

On MS plate – 3 rd layer (after SR at 450°C for 4 hours)
40-45 HRC

BASICITY INDEX : ~3.1

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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JUN 2017 (Rev.: 04)