Maxflux SAF- 4 (PW)

Agglomerated Basic Flux for Submerged Arc Welding

CODIFICATION: AWS: SFA 5.17 F7A4/P4EM12K, F8A4/F7P5EH14

CHARACTERISTICS: Maxflux SAF-4 (PW) is a basic type flux having very good performance with good sub-zero impact properties & extreme resistance to cracking. The flux is especially designed to meet the tensile & Impact requirements after post weld heat treatment condition at 620^0 C. slag is easily removable & bead finish is smooth & shiny. The diffusible hydrogen content of the weld metal is low.

APPLICATIONS: Maxflux SAF-4 (PW) 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
Autotherme Grade B	0.06	1.24	0.51	0.021	0.023
Autotherme Grade C	0.07	1.60	0.42	0.023	0.025

ALL-WELD MECHANICAL PROPERTIES:

	0.2% YS MPa	UTS MPa	EL (L=4d) %	Impact, J at -29°C	-40°C	-46°C
Autotherme Grade B (As welded)	486	537	28	106	78	
Autotherme Grade C (As welded)	506	568	28	94	68	48
Autotherme Grade B (PWHT620°C for 2 hrs)	450	512	30	103	66	
Autotherme Grade C (PWHT620°C for 2 hrs)	462	523	31	135	96	56

MAJOR CONSTITUENTS:

$SiO_2 + TiO_2$	CaO + MgO	$Al_2O_3 + MnO$	CAF_2
22%	23%	21%	34%

BASICITY INDEX : ~1.5

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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