



Maxflux SAF- 4 (Spl)



Agglomerated Basic Flux for Submerged Arc Welding

CODIFICATION:

AWS: SFA 5.17 F7A4EM-12K, F7A4/ P4EH-14, F7A4/ P4EH-10K

CHARACTERISTICS:

Maxflux SAF-4 (Spl) is a basic type flux giving good sub-zero impact properties and resistance to cracking. Slag detachability is very good with smooth & shiny bead finish. The diffusible hydrogen content of weld metal is low & satisfies radiographic quality requirements.

APPLICATIONS:

Maxflux SAF-4 (Spl) 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 B	0.06	1.32	0.25	0.028	0.026	0.15
Autotherme Grade C	0.06	1.58	0.22	0.028	0.027	0.15
Autotherme Grade E	0.06	1.46	0.28	0.012	0.015	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 B	475	528	25	80	70	40
Autotherme Grade C	488	545	26	100	80	50
Autotherme Grade C (after SR at 620°C/1hr)	464	517	29	106	78	60
Autotherme Grade E	490	536	26	120	86	62
Autotherme Grade E (after SR at 620°C/1hr)	474	508	28	107	84	65

MAJOR CONSTITUENTS:

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

BASICITY INDEX

: ~1.8

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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