



Maxflux SAF-5

Agglomerated basic flux for Submerged Arc Welding



CODIFICATION: AWS: SFA 5.17 F7A4EM-12K, F7A5EH-14, F7A5EH-10K

CHARACTERISTICS: Maxflux SAF-5 is a basic type flux for welding general structural steels, pressure vessel steels, pipe steels, micro-alloyed (BIS: 8500) & fine grained steels. Recommended to use with high Mn wires (like EM12K and EH14) for better impact properties. Slag detachability is good. Weld is of radiographic quality with very low diffusible hydrogen content.

APPLICATIONS: Maxflux SAF-5 is suitable for single & multi-layer welding of structural welding, 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	0.07	1.00	0.25	0.020	0.025	0.15
Autotherme Grade C	0.08	1.50	0.20	0.021	0.026	0.15
Autotherme Grade E	0.07	1.20	0.25	0.018	0.022	0.15

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	412	492	32	80	50	–
Autotherme Grade C	428	530	29	90	65	45
Autotherme Grade E	415	520	30	90	75	50

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
10%	40%	30%	20%

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

D&H Sécheron Electrodes Private Limited

44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260
E-mail: tsd@dnhsecheron.net Website: www.dnhsecheron.com

JUN 2017 (Rev.: 04)