



## Maxflux SAF - 704

Submerged Arc Welding Flux for Composite Wires



### CHARACTERISTICS:

Maxflux SAF-704 is a fluoride-basic type flux suitable to weld with composite SAW wires. The flux is neutral in nature and is also suitable with all HF (hard facing) class wires. The deposited weld metal has low diffusible hydrogen content and crack resistant during hard surfacing.

### APPLICATIONS:

Maxflux SAF-704 flux suited with composite SAW wires. With ECNi2 wire the weld metal gives excellent mechanical and charpy V-notch impact properties (40-70J at -51°C). For hard surfacing application on steel mill rolls, the flux is suitable with Maxfil HF-20, Maxfil HF-30, Maxfil HF-45 & Maxfil HF-55 wires depending upon the composition & hardness requirement. Recommended welding procedure shall be followed as in our product literature.

### ALL WELD METAL COMPOSITION (WITH MAXFLUX SAF-704 FLUX):

Wire	C	Mn	Si	Cr	Ni	Mo	N
Autotherme Gr HC	0.05-0.10	1.0-1.6	0.30-0.70	-	2.0-2.9	-	-
Maxfil HF-20	0.08 max	0.50-1.20	0.60 max	1.2-2.0	2.0-3.0	0.40-0.80	0.06-0.15
Maxfil HF-30	0.20 max	0.50-1.20	0.60 max	4.0-8.0	2.0-4.0	0.40-0.80	0.06-0.15
Maxfil HF-45	0.10-0.30	0.80-1.60	0.80 max	11.0-14.0	3.0-4.5	0.40-0.80	0.06-0.15
Maxfil HF-55	0.30-0.60	1.0-2.0	0.80 max	4.0-6.0	0.50-1.0	0.50-1.0	0.06-0.15

### ALL WELD METAL PROPERTIES (WITH MAXFLUX SAF-704 FLUX):

Wire	YS, MPa	UTS, MPa	EL (L=4d), %	Hardness 3L, HRC
Autotherme Gr HC	470-600	550-700	24.0-27.0	-
Maxfil HF-20	-	-	-	23-28
Maxfil HF-30	-	-	-	30-40
Maxfil HF-45	-	-	-	42-48
Maxfil HF-55	-	-	-	52-54

**BASICITY INDEX:** : 1.80-3.40

**DE TAP DENSITY:** : 1.10-1.40 gm/cc

**GRAIN SIZE:** : (+5BSS): 0%,(-10,+44 BSS):90-95%,(-100 BSS): 0-2%

**PACKAGING:** : 25 Kg Poly-lined Paper Bag

**RE-DRYING CONDITIONS:** : 300-350°C for one hour

**An ISO 9001: 2008 COMPANY**

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