



## Maxflux SAF-723

Agglomerated basic flux for Submerged Arc Welding



**CLASSIFICATION:** AWS: SFA 5.23 / F8P2EA4-A4, F8A4/F7P4-EA3-A3

**CHARACTERISTICS:** Maxflux SAF- 723 is an agglomerated flux to weld structural steels. The weld metal possesses good CVN toughness & produces smooth beads and excellent slag detachability. The weld metal gives very less diffusible hydrogen (<5 ml/100gms. of W.M.).

**APPLICATIONS:** Maxflux SAF-723 is suitable for single & multilayer welding of various structural, pressure vessels & other fabrication steels. Especially suitable for welding of ASTM steels: A204 Grade A, A516 Gr. B, C & IS 2002 type B, API Gr. 5L X60-X 80 etc.

**ALL WELD ANALYSIS, WT %:**

WITH	ELEMENTS	C	Mn	Si	S	P	Mo	Cu
AUTOTHERME GRADE-J	TYPICAL	0.075	1.54	0.18	0.018	0.023	0.48	0.15
AUTOTHERME GRADE-U	TYPICAL	0.07	1.65	0.36	0.014	0.017	0.56	0.17

**ALL WELD MECHANICAL PROPERTIES:**

DETAILS	PWHT	UTS (MPa)	0.2%YS (MPa)	%EI (L=4d)	CVN Impact (J)		
					-20°C	-30°C	-40°C
AUTOTHERME GRADE-J	620°C FOR 1 HR	608.0	528.0	27.2	105	88	-
AUTOTHERME GRADE-U	AW	620.0	550.0	22.2	-	-	> 27
	620°C FOR 1 HR	590.0	510.0	23.4	-	-	50

- BASICITY INDEX** : ~ 2.3
- GRAIN SIZE** : 0.35-1.20 mm
- PACKAGING** : 25 Kg Poly-lined paper bag
- RE-DRYING CONDITION** : 300°C-350°C for 2 Hours.

<p><b>An ISO 9001: 2008 COMPANY</b></p> <p><b>D&amp;H Sécheron Electrodes Private Limited</b></p> <p>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</p> <p style="text-align: right;">JUN 2017 (Rev.: 03)</p>
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