



# Maxflux SAF-7S

Agglomerated Acidic Flux for Submerged Arc Welding



**CODIFICATION:**

AWS: SFA 5.17 F7AZ-EL8, F7A0-EM12K

**CHARACTERISTICS:**

Maxflux SAF-7S is a high speed welding acidic flux for spiral pipe welding. The flux is suitable for single & multi-pass welding with single wire & multi-wire applications in both AC & DC polarity. Slag detachability is good and deposited weld metal is of radiographic quality.

**APPLICATIONS:**

Maxflux SAF-7S is suited for fabrication and welding of spiral pipes, smaller diameter pipes (internal and external), penstock pipelines, wind mill towers, pressure vessels, girder, earthmoving equipment, structures of off-shore platforms, etc.

**ALL-WELD ANALYSIS, WT %:**

	C	Mn	Si	S	P	Cu
Autotherme Grade A	0.05	1.30	0.60	0.025	0.024	0.15
Autotherme Grade B	0.06	1.55	0.75	0.027	0.020	0.15

**ALL-WELD MECHANICAL PROPERTIES:**

	0.2% YS MPa	UTS MPa	EL (L=4d) %	Impact, J at	
				-18°C	-29°C
Autotherme Grade A	480	550	23	40	–
Autotherme Grade B	535	580	23	50	32

**MAJOR CONSTITUENTS:**

SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CAF <sub>2</sub>
20%	5%	55%	15%

**BASICITY INDEX** : ~0.5

**GRAIN SIZE** : 0.20 – 1.50 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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