



Maxflux SAF-8 (LS) CTOD

Agglomerated basic flux for Submerged Arc Welding.



CODIFICATION: AWS SFA 5.17/ F7A6/P6/P8-EH10K, F7A8/P8-EH10K

CHARACTERISTICS: Maxflux SAF-8 (LS) CTOD is a fluoride-basic type flux suitable to weld medium to high strength steels and good CTOD fracture toughness properties was achieved for offshore constructions. The weld metal made with this flux gives very low diffusible hydrogen content, good crack resistance and higher sub-zero toughness properties. The flux is neutral in Mn & Si pick up and meets mechanical requirements after post-weld heat treatment at 620°C up to six hours of holding. The weld deposit is of radiographic quality. The weld metal passes the corrosion tests as per NACE standard TM-01-77 & TM-02-84.

APPLICATIONS: Maxflux SAF-8 (LS) CTOD is suitable for single & multi-layer welding of high tensile quenched & tempered steel, fine grained steels, heat resistant structural steels, nuclear sector fabrication, etc.

ALL-WELD ANALYSIS, WT %:

	C	Mn	Si	S	P	Cu
Autotherme Grade- E (CTOD)	0.086	1.58	0.36	0.012	0.013	0.15

ALL-WELD MECHANICAL PROPERTIES:
(With Autotherme Gr E(CTOD wire))

	UTS (MPa)	0.2% YS (MPa)	% EL (L=4d)	CVN Impact (J)at		
				-40°C	-51°C	-62°C
After PWHT at 620°C for 2 hours	535	438	30.0	105	86	72
After PWHT at 620°C for 6 hours	511	427	32.0	128	115	106

CTOD TEST: Satisfactory as per BS 7448-1991 Part 2 **Average CTOD =1.41 mm**

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
10%	48%	17%	25%

BASICITY INDEX : ~3.4

GRAIN SIZE : 0.35 – 1.60 mm (10 to 30 BSS)

PACKAGING : 25 kgs poly-lined printed paper bag

RE-DRYING CONDITIONS : 300-350°C for 2 hours

An ISO 9001: 2008 COMPANY

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JUN 2017 (Rev.: 07)