



# Maxflux SAF-8 (LS)

Agglomerated basic flux for Submerged Arc Welding



**CODIFICATION:**

AWS SFA 5.17/ F7A6/P6/P8-EH10K

**CHARACTERISTICS:**

Maxflux SAF-8 (LS) is a fluoride-basic type flux suitable to weld medium to high strength steels. 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) 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 %:**

Autotherme Grade- E

| C     | Mn   | Si   | S     | P     | Cu   |
|-------|------|------|-------|-------|------|
| 0.086 | 1.58 | 0.36 | 0.012 | 0.013 | 0.15 |

**ALL-WELD MECHANICAL PROPERTIES:**

(With Autotherme Grade E wire)

After PWHT at 620°C for 2 hours

After PWHT at 620°C for 6 hours

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

**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> |
|-------------------------------------|-----------|--------------------------------------|------------------|
| 10%                                 | 48%       | 17%                                  | 25%              |

**BASICITY INDEX**

: ~3.4

**GRAIN SIZE**

: 0.35 – 1.60 mm

**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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