



## Maxflux SAF-8(Mod)

Agglomerated basic flux for Submerged Arc Welding

**CODIFICATION:**

AWS: SFA 5.17 F8A5 EH-10K

**CHARACTERISTICS:**

Maxflux SAF-8 (Mod) is a fluoride-basic type flux suitable to weld medium to high strength steels where very low diffusible hydrogen content, good crack resistance and higher sub-zero toughness properties are desired from the weld metal. The flux is neutral in Mn & Si pick up and is alloyed with Molybdenum and Nickel. The weld deposit is of radiographic quality.

**APPLICATIONS:**

Maxflux SAF-8 (Mod) 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	Mo	Ni	Cu
0.085	1.55	0.21	0.010	0.013	0.25	0.40	0.15

**ALL-WELD MECHANICAL PROPERTIES:**

Autotherme Grade E

UTS (MPa)	0.2% YS (MPa)	%EL (L=4d)	Impact, J at		
			-29°C	-40°C	-46°C
568	520	24	140	124	110

**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 paper bag

**RE-DRYING CONDITIONS**

: 300°-350°C for 2 hours

**An ISO 9001: 2008 COMPANY****D&H Sécheron Electrodes Private Limited**

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