



Maxflux SAF-8 (PW)

Agglomerated basic flux for Submerged Arc Welding

**CODIFICATION:**

AWS: SFA 5.17 F7P5/ P6 EH-10K, F7P5/ P6 EH-14
F7P6/P8EH-12K

CHARACTERISTICS:

Maxflux SAF-8 (PW) 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 especially designed to meet the tensile & impact requirements after post-weld heat treatment condition up to 7 hours of holding at 620°C. The weld deposit is of radiographic quality.

APPLICATIONS:

Maxflux SAF-8 (PW) 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	0.097	1.60	0.38	0.011	0.013	0.15
Autotherme Grade C	0.092	1.72	0.28	0.021	0.026	0.15
Autotherme Grade E (Spl)	0.09	1.62	0.35	0.010	0.018	0.10

ALL-WELD MECHANICAL PROPERTIES:

	UTS (MPa)	0.2% YS (MPa)	EL (L=4d) %	CVN Impact, J at		
				-46°C	-51°C	-62°C
PWHT at 620°C/ 6 hrs (Gr. E wire)	520	450	33	126	50	-
PWHT at 620°C/ 2 hrs (Gr. C wire)	538	445	30	102	68	-
PWHT at 620°C/ 2 hrs (Gr. E (Spl) wire)	545	450	30	-	70	35
PWHT at 620°C/ 7 hrs (Gr. E (Spl) wire)	525	430	32	-	55	30

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 [BS 10 to 44]

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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