



Maxflux SAF-8 (Spl)

Agglomerated basic flux for Submerged Arc Welding



CODIFICATION: AWS: SFA 5.17 F7A5 EL-8

CHARACTERISTICS: Maxflux SAF-8 (Spl) 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 required from the weld metal. The flux is neutral in Mn & Si pick up. The weld deposit is of radiographic quality and satisfies the NACE corrosion criteria of weld metal for HIC & SSC tests with Grade A (Spl) wire.

APPLICATIONS: Maxflux SAF-8 (Spl) 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 A	0.05	1.35	0.18	0.010	0.011	0.15

ALL-WELD MECHANICAL PROPERTIES:

	UTS (MPa)	0.2% YS (MPa)	EL (L=4d) %	CVN Impact, J at	
				-40°C	-46°C
Autotherme Grade A	503	457	31	156	140

MAJOR CONSTITUENTS:

SiO₂ + TiO₂	CaO + MgO	Al₂O₃ + MnO	CaF₂
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

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