



# Maxflux SAF-9C

Agglomerated basic flux for Submerged Arc Welding



**CODIFICATIONS:** AWS SFA 5.23 F8A5/A6 ECNi2-Ni2

**CHARACTERISTICS:**

Maxflux SAF-9C is a fluoride-basic type flux suitable to weld with Autotherme Grade-H (ENi-2) & Autotherme Grade H(C) (ECNi2) wires for medium to high tensile strength steel, fine grained structural steels where very low diffusible hydrogen content, good crack resistance and higher sub zero toughness properties are desired from the weld metal. The weld deposit with these wires & flux is of radiographic quality.

**APPLICATIONS:**

Maxflux SAF-9C is suitable for single and multi-layer welding of high strength quench & tempered steel, ASTM 516 Gr.70 or Equivalent grade of steels, fine grained & heat resistance structural steels, nuclear sector fabrication etc.

**CHEMICAL COMPOSITION OF SOLID & COMPOSITE WIRE, WT. %:**

	C	Mn	Si	S	P	Ni	Cu
With Autotherme Grade H (ENi2) & Autotherme Grade H (C) (ECNi2) wire	0.05-0.10	1.0-1.6	0.30-0.70	0.028 Max	0.028 Max	2.0-2.9	0.10-0.30

**MECHANICAL PROPERTIES OF ALL WELD METAL:**

With Autotherme Grade H (ENi2) & Autotherme Grade H (C) (ECNi2) wire	UTS (MPa)	0.2%YS (MPa)	%El, L=5d (%)	CVN Impact (J) at	
				-46°C	-51°C
	550-700	470-600	24.0-27.0	50-80	40-70

**MAJOR CONSTITUENTS:**

<b>SiO<sub>2</sub> + TiO<sub>2</sub></b>	<b>CaO + MgO</b>	<b>Al<sub>2</sub>O<sub>3</sub> + MnO</b>	<b>CaF<sub>2</sub></b>
10%	42%	18%	30%

**BASICITY INDEX** : 1.80-3.40

**DE TAP DENSITY** : 1.10-1.40 gm/cc

**GRAIN SIZE** : (+5BSS): 0%, (-10,+44 BSS):90-95%, (-100 BSS): 0-2%

**PACKAGING** : 25 Kg Poly-lined Paper Bag

**RE-DRYING CONDITIONS** : 300-350°C for one hour

**An ISO 9001: 2008 COMPANY**

**D&H Sécheron Electrodes Private Limited**

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