
	<h1>Maxflux SS-4</h1>	
	<p>Agglomerated Flux for Submerged Arc Welding</p>	

CHARACTERISTICS:

Maxflux SS-4 is a fluoride basic agglomerated type flux suitable for welding of austenitic stainless steel and heat resistant steels. The flux behavior to carbon content of the weld metal is neutral. So, using suitable wire, low carbon stainless steels can easily be welded. The flux offers good slag detachability, smooth weld finish and less than 5ml diffusible hydrogen per 100 gm of weld metal.

APPLICATIONS:

Maxflux SS-4 flux can be used with various stainless steel wires for joining & for overlay applications. The flux is also suitable with various Cr- Mo steels & stabilized grade stainless steel. With AISI 430 wire the weld metal result 30-40 HRC.

ALL-WELD ANALYSIS, WT %:	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
With Autotherme Grade 430 wire	0.05	0.50	0.35	16.3	-	-	0.30	0.012	0.025
With Autotherme Grade 308 wire	0.05	1.20	0.35	20.5	9.8	-	0.30	0.012	0.025
With Autotherme Grade 309 wire	0.05	1.50	0.35	24.0	12.5	-	0.30	0.012	0.025
With Autotherme Grade 312 wire	0.07	1.40	0.35	28.8	10.1	-	0.30	0.012	0.025
With Autotherme Grade 316 wire	0.05	1.20	0.35	18.5	12.5	2.30	0.30	0.012	0.025

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
20%	30%	20%	25%

BASICITY INDEX : ~2.0

GRAIN SIZE : 0.35 – 1.60 mm

PACKAGING : 25 kgs poly-lined paper bag

RE-DRYING CONDITIONS : 300°-350°C for 2 hours

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