



Maxflux SS-4 (LT)

Agglomerated flux for Submerged Arc Welding



CHARACTERISTICS:

Maxflux SS-4 (LT) 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 (LT) can be used with various low carbon stainless steel wires for joining & for overlay applications. Weld metal meet impact toughness at -196°C requirements. The flux is also suitable to weld with various Cr-Mo steels & stabilized grade stainless steels.

ALL-WELD ANALYSIS, WT %:	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
With Autotherme Grade 308L wire	0.03	1.20	0.35	20.5	9.8	-	0.30	0.030	0.025
With Autotherme Grade 316L wire	0.03	1.20	0.35	18.5	12.5	2.30	0.30	0.030	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

An ISO 9001: 2008 COMPANY

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