

CODIFICATION:

AWS: SFA 5.17/ 5.23 F7A2EL8, F7A4/ A5-EM12K, F8A2-EA2-A2, F7A4/P4EH14

CHARACTERISTICS:

Maxflux SAF-223 (SPL) is an agglomerated basic type flux for high-speed longitudinal welding giving smooth bead and easy slag removal characteristics. The flux is also suitable for Tandem, multi-wire submerged arc welding applications and supports to achieve higher throat thickness in welding of fillet joints due to higher current carrying capacity.

APPLICATIONS:

Maxflux SAF-223 (SPL) is suitable for Tandem single & multi-layer welding of pressure vessel grade steels (EN 10028-2), pipes conforming to X-42 to X-70 grade of API 5L, Grade 1/2/3 of ASTM A252, SA 516 Grade 70, Grade A/B of A53 & A523 specification, etc. Suitable for AC and DC welding.

ALL-WELD ANALYSIS, WT. %:

Autotherme Gr A (EL8)
Autotherme Gr B (EM12K)
Autotherme Gr C (EH14)
Autotherme Gr F (EA2)

	C	Mn	Si	S	P	Mo	Cu
Autotherme Gr A (EL8)	0.060	0.90	0.22	0.025	0.025	-	0.15
Autotherme Gr B (EM12K)	0.065	1.1	0.28	0.024	0.025	-	0.15
Autotherme Gr C (EH14)	0.059	1.82	0.30	0.010	0.030	-	0.16
Autotherme Gr F (EA2)	0.07	1.38	0.60	0.020	0.022	0.48	0.15

ALL-WELD MECHANICAL PROPERTIES:

Autotherme Gr A (EL8)
Autotherme Gr B (EM12K)
Autotherme Gr C (EH14) (AW)
Autotherme Gr C (EH14) (PW)
(After PWHT at 620°C/1 hour)
Autotherme Gr F (EA2)

	UTS (MPa)	0.2% YS (MPa)	EL (L=4d) %	CVN Impact. J at		
				-29°C	-40°C	-46°C
Autotherme Gr A (EL8)	520	435	31	64	-	-
Autotherme Gr B (EM12K)	540	445	30	85	65	52
Autotherme Gr C (EH14) (AW)	536	435	29	-	62	-
Autotherme Gr C (EH14) (PW) (After PWHT at 620°C/1 hour)	526	418	30	-	78	-
Autotherme Gr F (EA2)	620	536	26	75	-	-

MAJOR CONSTITUENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
14%	38%	26%	22%

Basicity Index : ~1.6

Grain Size : 0.35 – 1.20 mm

Packaging : 25 kg poly-lined paper bag

Re-drying Conditions : 300° - 350°C for 2 hours

An ISO 9001: 2008 COMPANY

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OCT 2017 (Rev.: 07)