



Maxflux SAF -7X



Agglomerated acidic flux for Submerged Arc Welding.

ODIFICATION:

AWS: SFA 5.17 F7AZEL8, F7A0EM12K

CHARACTERISTICS:

Maxflux SAF-7X is an acidic flux for longitudinal & spiral high speed pipe welding applications. The flux is suitable for single & multi-pass welding with single wire & multi-wire applications in both AC & DC polarity. Slag detachability is good and deposited weld metal is of radiographic quality.

APPLICATIONS:

Maxflux SAF-7X is suited for fabrication and welding of longitudinal pipe, spiral pipes, penstock pipelines, wind mill towers, pressure vessels, girder, earthmoving equipment, structures of off-shore platforms, etc.

ALL WELD ANALYSIS, WT. %:

WITH AUTOTHERME GRADE-A
WITH AUTOTHERME GRADE-B

C	Mn	Si	S	P	Cu
0.05	1.30	0.56	0.025	0.024	0.15
0.08	1.55	0.69	0.028	0.026	0.16

MECHANICAL PROPERTIES OF ALL WELD METAL AS WELDED CONDITION

WITH AUTOTHERME GRADE- A
WITH AUTOTHERME GRADE- B

UTS (MPa)	0.2 %YS (MPa)	% EL. (L=4d)	CVN Impact (J) at	
			-18°C	-29°C
530.0	440.0	24.2	40	-
552.0	465.0	28.5	80	52

BASICITY INDEX : ~0.6

GRAIN SIZE : 0.20-1.50 mm

PACKAGING : 25 Kg poly-lined paper bag

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

An ISO 9001: 2008 certified company

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