MAXFLUX SAF-3

CODIFICATION:

AWS/SFA 5.17
F7A0-EL8, F7A0-EM12K

CHARACTERISTICS AND APPLICATIONS:

Maxflux SAF-3 is an agglomerated Alumina-Rutile type acidic agglomerated flux to weld medium tensile structural steels. The slag is easy to remove and the weld deposit is of radiographic quality.

Maxflux SAF-3 is suited for fabrication and welding of penstock pipelines, pressure vessels, earthmoving equipment, off-shore platforms, boilers, rail & crane girders, machine building, locomotive works, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

WITH SAW WIRE	ELEMENTS	C	Mn	Si	S	P	Cu
AUTOTHERME GRADE-A	TYPICAL	0.050	1.200	0.450	0.027	0.028	0.150
AUTOTHERME GRADE-B	TYPICAL	0.070	1.350	0.500	0.028	0.026	0.150

MECHANICAL PROPERTIES OF ALL WELD METAL:

WITH SAW WIRE	UTS (Mpa)	0.2% YS (Mpa)	% El (L = 4d)	CVN Impact (Joules) RT	0°C	-20°C
AUTOTHERME GRADE-A	500	410	26	-	55	30
AUTOTHERME GRADE-B	510	418	25	-	60	40

MAJOR CONSTITUTENTS:

$SiO_2 + TiO_2$	$CaO + MgO$	$Al_2O_3 + MnO$	CaF_2
20%	10%	45%	25%

PRECAUTIONS: Re-dry the flux at 300-350°C for two hours before use.

ADDITIONAL INFORMATION :

BASICITY INDEX : ~ 0.70
GRAIN SIZE : 0.35 – 1.60 mm
PACKAGING : 25 Kg POLY-LINED PAPER BAG