



MAXFLUX SAF-4 (SPL)

CODIFICATION: AWS/SFA A5.17 EN ISO 14174
F7A4-EM12K, F7A4/P4-EH14, SAFB 167 DC
F7A4/ P4-EH10K

CHARACTERISTICS AND APPLICATIONS:

Maxflux SAF-4 (Spl) is a basic type flux giving good sub-zero impact properties and resistance to cracking. Slag detachability is very good with smooth & shiny bead finish. The diffusible hydrogen content of weld metal is low & satisfies radiographic quality requirements.

Maxflux SAF-4 (Spl) is suitable for single & multi-layer welding of structural steels, pressure vessels, boilers and other fabrications involving medium tensile & low alloy steel.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

WITH SAW WIRE	ELEMENTS	C	Mn	Si	S	P	Cu
AUTOTHERME GRADE-B	TYPICAL	0.060	1.320	0.600	0.022	0.028	0.150
AUTOTHERME GRADE-C	TYPICAL	0.070	1.580	0.220	0.028	0.027	0.150
AUTOTHERME GRADE-E	TYPICAL	0.060	1.460	0.280	0.012	0.015	0.150

MECHANICAL PROPERTIES OF ALL WELD METAL:

WITH SAW WIRE	UTS (Mpa)	0.2% YS (Mpa)	% EI (L = 4d)	CVN Impact (Joules)		
				-18°C	-29°C	-40°C
AUTOTHERME GRADE-B	528	475	25	80	70	40
AUTOTHERME GRADE-C	545	488	26	100	80	50
AUTOTHERME GRADE-C	517	464	29	106	78	60
AFTER SR : 620°C / 1 HR						
AUTOTHERME GRADE-E	508	474	28	120	86	62
AFTER SR : 620°C / 1 HR						

MAJOR CONSTITUTENTS:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
20%	25%	20%	35%

APPROVALS: CE MARKING

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

ADDITIONAL INFORMATION :

BASICITY INDEX : ~ 1.70
GRAIN SIZE : 0.35 – 1.60 mm
PACKAGING : 25 Kg POLY-LINED PAPER BAG