



MAXFLUX SAF-7S

CODIFICATION: AWS/SFA 5.17
F7AZ-EL8, F7A0-EM12K

CHARACTERISTICS AND APPLICATIONS:

Maxflux SAF-7S is a high speed welding acidic agglomerated flux for spiral pipe welding. 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.

Maxflux SAF-7S is suited for fabrication and welding of spiral pipes, smaller diameter pipes (internal and external), penstock pipelines, wind mill towers, pressure vessels, girder, earthmoving equipment, structures of off-shore platforms, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

WITH SAW WIRE	ELEMENTS	C	Mn	Si	S	P	Cu
AUTOTHERME GRADE-A	TYPICAL	0.050	1.300	0.600	0.025	0.024	0.150
AUTOTHERME GRADE-B	TYPICAL	0.060	1.550	0.750	0.027	0.020	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
AUTOTHERME GRADE-A	550	480	23	40	-
AUTOTHERME GRADE-B	580	535	23	50	32

MAJOR CONSTITUTENTS:

SiO₂ + TiO₂	CaO + MgO	Al₂O₃ + MnO	CaF₂
20%	5%	55%	15%

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

ADDITIONAL INFORMATION :

BASICITY INDEX : ~ 0.50
 GRAIN SIZE : 0.20 – 1.50 mm
 PACKAGING : 25 Kg POLY-LINED PAPER BAG