



MAXFLUX SAF-8(LS)

CODIFICATION:	AWS/SFA 5.17	EN ISO 14174
	F7A2/P2-EM12K	SAFB 167 DC
	F7A6/P6/P8-EH10K	

CHARACTERISTICS AND APPLICATIONS:

Maxflux SAF-8 (LS) is an agglomerated fluoride-basic type flux suitable to weld medium to high strength steels. The weld metal made with this flux gives very low diffusible hydrogen content, good crack resistance and higher sub-zero toughness properties. The flux is neutral in Mn & Si pick up and meets mechanical requirements after post-weld heat treatment at 620°C up to six hours of holding. The weld deposit is of radiographic quality. The weld metal passes the corrosion tests as per NACE standard TM-01-77 & TM-02-84.

Maxflux SAF-8 (LS) is suitable for single & multi-layer welding of high tensile quenched & tempered steel, fine grained steels, heat resistant structural steels, nuclear sector fabrication, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

WITH SAW WIRE	ELEMENTS	C	Mn	Si	S	P	Cu
AUTOTHERME GRADE-B	TYPICAL	0.010	1.200	0.470	0.010	0.030	0.080
AUTOTHERME GRADE-E	TYPICAL	0.086	1.580	0.360	0.012	0.013	0.150

MECHANICAL PROPERTIES OF ALL WELD METAL:

WITH SAW WIRE	UTS (Mpa)	0.2% YS (Mpa)	% EI (L = 4d)	CVN Impact (Joules)			
				-29°C	-40°C	-51°C	-62°C
AUTOTHERME GRADE-B (AS WELDED)	570	450	26	74	-	-	-
AUTOTHERME GRADE-B (SR:620°C/7HRS)	545	438	29	90	-	-	-
AUTOTHERME GRADE-E (SR:620°C/2HRS)	535	438	30	-	105	86	72
AUTOTHERME GRADE-E (SR:620°C/6HRS)	511	427	32	-	128	115	106

MAJOR CONSTITUENTS:

SiO₂ + TiO₂	CaO + MgO	Al₂O₃ + MnO	CaF₂
10%	48%	17%	25%

APPROVALS: CE MARKING, BV, L&T, TEMA INDIA, ISGEC HITACHI, ANUP ENGG.

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

ADDITIONAL INFORMATION :

BASICITY INDEX	: ~ 3.40
GRAIN SIZE	: 0.35 – 1.60 mm
PACKAGING	: 25 Kg POLY-LINED PAPER BAG