



## MAXFLUX SAF-8(PW)

**CODIFICATION:**                      AWS/SFA 5.17                                      EN ISO 14174  
     F7P5/P6-EH10K,                                      SAFB 167 DC  
     F7P5/P6-EH14, F7P6/P8-EH12K

### CHARACTERISTICS AND APPLICATIONS:

Maxflux SAF-8 (PW) is an agglomerated fluoride-basic type flux suitable to weld medium to high strength steels where very low diffusible hydrogen content, good crack resistance and higher sub-zero toughness properties are desired from the weld metal. The flux is neutral in Mn & Si pick up and especially designed to meet the tensile & impact requirements after post-weld heat treatment condition up to 7 hours of holding at 620°C. The weld deposit is of radiographic quality.

Maxflux SAF-8 (PW) 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-E	TYPICAL	0.097	1.60	0.38	0.011	0.013	0.15
AUTOTHERME GRADE-C	TYPICAL	0.092	1.72	0.28	0.021	0.026	0.15
AUTOTHERME GRADE-E SPL	TYPICAL	0.090	1.62	0.35	0.010	0.018	0.10

### MECHANICAL PROPERTIES OF ALL WELD METAL:

WITH SAW WIRE	UTS (Mpa)	0.2% YS (Mpa)	% EI (L = 4d)	CVN Impact (Joules)		
				-46°C	-51°C	-62°C
AUTOTHERME GRADE-E (SR : 620° 6HRS)	520	450	33	126	50	-
AUTOTHERME GRADE-C (SR : 620°/2 HRS)	538	445	30	102	68	-
AUTOTHERME GRADE-E SPL (SR : 620°C/7 HRS)	525	430	32	-	55	30

### MAJOR CONSTITUTENTS:

<b>SiO<sub>2</sub> + TiO<sub>2</sub></b>	<b>CaO + MgO</b>	<b>Al<sub>2</sub>O<sub>3</sub> + MnO</b>	<b>CaF<sub>2</sub></b>
10%	48%	17%	25%

### APPROVALS: CE MARKING

**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 (BS 10 TO 44)  
 PACKAGING                            :    25 Kg POLY-LINED PAPER BAG