MAXFLUX SAF-NA

CODIFICATION

AWS/SFA 5.39	AWS/SFA 5.39M
F110A32-ENiCr-3/NiCr-3	F760A20-ENiCr-3/NiCr-3
F110A32-ENiCrMo-3/NiCrMo-3	F760A20-ENiCrMo-3/NiCrMo-3
F105AZ- ENiCrMo-4/NiCrMo-4	F730AZ- ENiCrMo-4/NiCrMo-4

CHARACTERISTICS AND APPLICATIONS:

Maxflux SAF-NA is an agglomerated basic type flux for welding of Nickel alloys (Inconel 600, Inconel 625, Inconel 800, Hastelloy C276), 9% Nickel steels & also for surfacing of Nickel alloys on stainless steels when used with a suitable wire combination. This flux have applications in petrochemical industry, power generation & furnace equipment fabrication.

CHEMICAL COMPOSITION OF ALL WELD METAL (%)

WITH SAW WIRE	ELEMENT	C	Mn	Si	Cr	Mo	Fe	Co	W	S	P	Ni
AUTOTHERME GRD NiCr-3	TYPICAL	0.008	2.9	0.35	19.6	-	1.2	-	-	0.01	0.004	Bal.
AUTOTHERME GRD NiCrMo-3	TYPICAL	0.007	0.6	0.36	21.5	9.1	5.2	-	-	0.01	0.004	Bal.
AUTOTHERME GRD NiCrMo-4	TYPICAL	0.007	0.4	0.17	14.8	15.1	6.5	0.06	3.5	0.01	0.005	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL:

WITH SAW WIRE	UTS (MPa)	%AGE ELONGATION	Impact at -196°C (J)
AUTOTHERME GRADE-NiCr-3	760	32	30
AUTOTHERME GRADE- NiCrMo-3	760	35	30
AUTOTHERME GRADE- NiCrMo-4	730	29	-

Major Constituents

CaF_2+MgO	Al_2O_3+MnO	SiO_2+TiO_2	CaO
25%	35%	30%	10%

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

ADDITIONAL INFORMATION:

BASICITY INDEX : 1.4-1.5
GRAIN SIZE : 0.25 - 1.60 mm
PACKAGING : 25 Kg POLY-LINED PAPER BAG