



MAXFLUX SAF-8(LS)



Codification :

AWS SFA 5.17	F7A4/P4-EM12K, F7A6/P6-EH10K, F8A4/F7P4-EH14
EN ISO 14174	SAFB 167 DC

Characteristics & 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 weld metal produces excellent smooth beads, good wetting, and excellent slag detachability at different range of welding speed (Heat input). 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, Bead finish at wide range of welding parameters, nuclear sector fabrication, etc.

Typical Chemical Composition of All Weld Metal (%):

With SAW Wire	C	Mn	Si	P	S	Cu
AUTOTHERME Gr.B	0.010	1.200	0.470	0.030	0.010	0.080
AUTOTHERME Gr-C	0.070	1.400	0.500	0.030	0.010	0.080
AUTOTHERME Gr-E	0.070	1.400	0.700	0.025	0.012	0.150
AUTOTHERME Gr-E(SPL)	0.075	1.550	0.700	0.025	0.012	0.080

Typical Mechanical Properties of All Weld Metal :

With SAW Wire	UTS (MPa)	YS (MPa)	%EI (L=4d)	CVN Impact Strength (J)		
				-29°C	-40°C	-51°C
AUTOTHERME Gr.B (AW)	570	450	26	74	-	-
AUTOTHERME Gr-B (SR:620°C/7HRS)	545	438	29	90	-	-
AUTOTHERME Gr-C (AW)	568	470	28	94	68	48

AUTOTHERME Gr-E (SR:620°C/2HRS)	535	438	30	-	105	86
AUTOTHERME Gr-E (SR:620°C/6HRS)	511	427	32	-	128	70
AUTOTHERME Gr-E(SPL) (AW)	601	500	34	-	140	100
AUTOTHERME Gr-E(SPL) (SR:620°C/7HRS)	525	430	30	-	130	80

Major Constituents :

SiO ₂ + TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO
25%	50%	25%

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

Precautions :

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

Additional Information:

Basicity Index : ~3.0

Grain Size : 0.35-1.60mm

Packaging : 25 Kg POLY-LINED PAPER BAG