

ROYAL FLUX-4

ALUMINA-BASIC TYPE AGGLOMERATED
SUBMERGED ARC WELDING FLUX

GRAIN SIZE = 8 X 60 BSS (0.25-2.00MM)
AWS: SFA/A 5.17 F7A4-EM12K
EN ISO 14174-A S AB 1 78 AC
B.I. = 1.60

KEY FEATURES:

ROFLX-4 is an agglomerated basic type flux for welding general structural steels, pressure vessel steels, pipe steels & fine grained steels. Slag detachability is good. Weld is of radiographic quality with very low diffusible hydrogen content.

APPLICATIONS

- Pressure vessel
- X70 and X80 grade pipe applications
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- low alloy high strength steel welding

RE-DRY CONDITION

- Re-drying recommended at 350°C for one hour before use.

MAIN CONSTITUTION(%)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
15	35	25	20

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-12K	0.080	1.40	0.40	0.016	0.022

MECHANICAL PROPERTIES

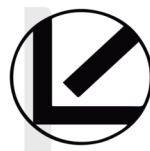
UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT 0°C -20°C
ROSUB-12K	470	580	26	100 J 60 J

WELDING POSITION

1G/1F



2G/2F



PACKING SPECIFICATION

PACKED IN POLYTHENE-LINE PAPER BAGS OF 25.00 KG NET WEIGHT.