

ROYAL FLUX-61

CA-MN SILICATE TYPE AGGLOMERATED SAW FLUX
FOR HIGH SPEED WELDING

GRAIN SIZE = 10X 60 BSS (0.25-1.60MM)
AWS: SFA/A 5.17 F7A0-EL8
EN ISO 14174-A S MS 1 67 AC
B.I. = 1.00

KEY FEATURES:

ROFLX-61 Calcium-manganese silicate type high speed welding flux with excellent slag detachability and smooth weld bead. It is welding with single and multi-wire procedure. It is active flux with high pick up Si and MN, Radiographic quality welds. Smooth and shiny weld bead. Easy-to-remove slag, even in root runs.

APPLICATIONS

- general construction, welding on structural steel
- pressure vessels and water pipes
- feasible for welding on a little rusty or oily plates also
- twin and multi wire welding
- suited in high speed welding
- spiral pipe mills and also high speed beam 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
30	20	40	10

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-8	0.085	1.20	0.65	0.015	0.022
ROSUB-12K	0.095	1.40	0.70	0.018	0.020

MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT 0°C -20°C	
ROSUB-8	440	520	28	60 J	-----
ROSUB-12K	480	570	26	80 J	60 J

WELDING POSITION



PACKING SPECIFICATION

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