

ROYAL FLUX-81

ACIDIC RUTILE-ALUMINATYPE AGGLOMERATED SAW
FLUX FOR HIGH SPEED WELDING

GRAIN SIZE = 10X 60 BSS (0.25-1.60MM)
AWS: SFA/A 5.17 F7AZ-EL8
EN ISO 14174-A S RS 1 67 AC
B.I. = 0.80

KEY FEATURES:

ROFLX-81 is an agglomerated Acidic Aluminate Rutile-Silicate Type Flux specially designed for butt and Fillet welding with high speed welding. Excellent slag removal and exceptional bead finish. It is preferably used for welding thin plates at speeds higher than up to 2m/min. It provides good welding usability, easy slag removal, excellent anti-porosity property and beautiful bead appearance

APPLICATIONS

- high speed beam welding process with twin wires
- general construction
- membrane wall panels, beam fabrications
- automotive etc
- sheet fillet welding and single pass welding with both of sides

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
25	10	50	10

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-8	0.070	1.30	0.70	0.018	0.022
ROSUB-12K	0.095	1.40	0.75	0.018	0.020

MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT +20°C 0°C
ROSUB-8	400	510	26	60 J --
ROSUB-12K	450	520	28	60 J --

WELDING POSITION



PACKING SPECIFICATION

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