

# ROYAL FLUX-SPL

HIGH -BASIC TYPE AGGLOMERATED SUBMERGED  
ARC WELDING FLUX

GRAIN SIZE = 8 X 60 BSS (0.25-2.00MM)  
AWS: SFA/A 5.17/A5.23  
F8A4-F7A4-EM14 F7A2-EA2  
B.I. = 2.20

## KEY FEATURES:

ROFLX-Spl an agglomerated Highly basic type submerged arc welding flux. It is used with operational properties for single double and multi wire system. It gives impact resistance subzero and minus temperature. The flux can be used with EL8, EM12K, EH14 and EA2

## APPLICATIONS

- fillet welding and single or multi pass butt welding with low, medium and high tensile steels
- Single wire tandem and multi-wire welding is possible for increased productivity

## RE-DRY CONDITION

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

## MAIN CONSTITUTION(%)

| SiO <sub>2</sub> +TiO <sub>2</sub> | CaO+MgO | Al <sub>2</sub> O <sub>3</sub> +MnO | CaF <sub>2</sub> |
|------------------------------------|---------|-------------------------------------|------------------|
| 15                                 | 35      | 20                                  | 25               |

## CHEMICAL COMPOSITION:

| UNDER Wires | C     | Mn   | Si   | S     | P             |
|-------------|-------|------|------|-------|---------------|
| ROSUB-8     | 0.080 | 1.20 | 0.50 | 0.015 | 0.020         |
| ROSUB-12K   | 0.070 | 1.40 | 0.40 | 0.018 | 0.022         |
| ROSUB-14    | 0.11  | 1.70 | 0.25 | 0.012 | 0.015         |
| ROSUB-A2    | 0.080 | 1.10 | 0.25 | 0.015 | 0.018/Mo-0.40 |

## MECHANICAL PROPERTIES

| UNDER Wires | YS (N/mm <sup>2</sup> ) | UTS (N/mm <sup>2</sup> ) | EL % | CHARPY "V" NOTCH<br>IMPACT AT<br>JoulesTemperatures(°) |     |
|-------------|-------------------------|--------------------------|------|--------------------------------------------------------|-----|
| ROSUB-8     | 400                     | 500                      | 25   | 45                                                     | -20 |
| ROSUB-12K   | 450                     | 580                      | 26   | 50                                                     | -40 |
| ROSUB-14    | 500                     | 600                      | 22   | 40                                                     | -40 |
| ROSUB-A2    | 520                     | 620                      | 22   | 40                                                     | -20 |

## WELDING POSITION

1G/1F



2G/2F



## PACKING SPECIFICATION

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