

ROYAL FLUX-SS

GRAIN SIZE = 10X 60 BSS (0.25-1.60MM)

B.I. = 2.80

SPECIAL DESIGNED SAW FLUX USED FOR WELDING
STAINLESS STEELS AND HEAT RESISTANT STEELS

KEY FEATURES:

Roflx-SS is a Fluoride basic agglomerated type flux suitable for welding of austenitic stainless steel and heat resistant steels. The flux behaviour to carbon content of the weld metal is neutral combination with the wire electrodes of AWS/SFA 5.9 in respect to the weld metal, Flux has no chromium compensation, despite this there is very little loss of chromium. The metallurgical behaviour in respect to silicon and manganese is neutral.

APPLICATIONS

- welding on high alloy Cr-Ni steels type: AISI 304,304L,316, 316L,347,321,318,410,430 etc.

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	40	15	25

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	Cr	Ni	Mo	Others
ROSUB-308L	0.026	1.450	0.55	19.60	9.11	--	S&P<0.020
ROSUB-316L	0.025	1.40	0.50	18.50	11.20	2.10	S&P<0.020

MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT +20°C
ROSUB-308L	450	560	40	100 J
ROSUB-316L	420	540	35	80 J

WELDING POSITION



1G/1F



2G/2F

PACKING SPECIFICATION

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