

ROYAL FLUX-1

ALUMINA-MANGANESE SILICATE TYPE
AGGLOMERATED SUBMERGED ARC WELDING FLUX

GRAIN SIZE = 8 X 60 BSS (0.25-2.00MM)
AWS: SFA/A 5.17 F7A0-EL8
EN ISO 14174-A S AS 1 67 AC
B.I. = 0.80

KEY FEATURES:

ROFLX-1 is saw flux for welding mild steel and medium tensile steels to get x-ray quality welds. Good mechanical properties with smooth and shiny weld bead. Auto removable slag even in the case of the root runs

APPLICATIONS

- offshore platforms, ships
- , pressure vessels and boilers involving steels
- Machine building
- automobiles, locomotives, earthmoving equipment
- penstocks and pipe works 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	S	P
30-40	10-20	30-50	10	≤0.07	≤0.07

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-8	0.085	1.10	0.55	0.016	0.020
ROSUB-12K	0.095	1.20	0.45	0.015	0.018

MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT 0°C -20°C	
ROSUB-8	450	530	28	60 J	---
ROSUB-12K	460	555	26	80 J	60 J

WELDING POSITION

1G/1F



2G/2F



PACKING SPECIFICATION

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