

ROYAL FLUX-2

ALUMINA-BASIC TYPE AGGLOMERATED
SUBMERGED ARC WELDING FLUX

GRAIN SIZE = 8 X 60 BSS (0.25-2.00MM)
AWS: SFA/A 5.17 F7A2-EM12K
EN ISO 14174-A S AB 1 67 AC
B.I. = 1.60

KEY FEATURES:

ROFLX-2 is an agglomerated Si & Mn alloying submerged arc welding flux for the high speed welding of both butt and fillet welds in structural steel components. It is suitable for the single pass, double pass and multipass welding of steel section up to 25mm thickness.

APPLICATIONS

- low and medium tensile steels
- AC & DC current with single wire, twin wire and multi wire systems
- Pressure vassels
- boilers
- LPG cylinder
- Pipes

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
25-35	10-20	30-50	10	≤0.07	≤0.07

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-8	0.080	1.40	0.50	0.016	0.020
ROSUB-12K	0.080	1.60	0.35	0.014	0.021

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	26	50 J	---
ROSUB-12K	480	550	24	80 J	50 J

WELDING POSITION

1G/1F



2G/2F



PACKING SPECIFICATION

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