

ROYAL FLUX-3

BASIC-ALUMINATE TYPE AGGLOMERATED
SUBMERGED ARC WELDING FLUX

GRAIN SIZE = 8 X 60 BSS (0.25-2.00MM)
AWS: SFA/A 5.17 F7A2-EM14
EN ISO 14174-A S AB 67 AC
B.I. = 1.60

KEY FEATURES:

ROFLX-3an agglomerated Flux designed for Submerged ArcWelding of mild, medium and high tensile steels in combination with ROSUB-3(EH14) Saw wire, to give excellent mechanical properties and impacts down to -40 °C with extreme resistance to cracking. Owing to insensitivity to rust, scale, primer on the surface to be welded, has excellent x-ray characteristics and slag removal.

APPLICATIONS

- mild steel and low alloy steel
- single and multipass welding
- Pressure vassels
- boilers
- fabrications involving medium tensile

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
20	30	30	20

CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-3	0.12	1.60	0.40	0.012	0.015

MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT 0°C -20°C
ROSUB-3	470	580	24	100 J 60 J

WELDING POSITION

1G/1F



2G/2F



PACKING SPECIFICATION

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