



"WELD WITH THE BEST"

SUBMERGED ARC WELDING FLUX

**SnFLUX™ 704**

### Characteristics & Applications:

SnFLUX 704 is a fluoride-basic type flux suitable to weld with composite SAW wires. The flux is neutral in nature and is also suitable with all HF (Hard Facing) class wires. The deposited weld metal has low diffusible hydrogen content and crack resistant during hard surfacing.

SnFLUX 704 flux suitable with composite SAW wires for hard surfacing application on steel mill rolls, the flux is suitable with HF-20, HF-30, HF-45, & HF-55 wires depending upon the composition & hardness requirement.

### Chemical Composition of All-Weld Metal, wt% (Typical)

Composite Wire	C	Mn	Si	Cr	Ni	Mo	Mo
HF-20	0.08 Max	0.50-1.20	0.60 Max	1.2-2.0	2.0-3.0	0.40-0.80	0.06-0.15
HF-30	0.20 Max	0.50-1.20	0.60 Max	4.0-8.0	2.0-4.0	0.40-0.80	0.06-0.15
HF-45	0.10-0.30	0.80-1.60	0.80 Max	11.0-14.0	3.0-4.5	0.40-1.00	0.06-0.15
HF-55	0.30-0.60	1.0-2.0	0.80 Max	4.0-6.0	0.50-1.0	0.50-1.0	0.06-0.15

### Hardness Properties of All-Weld Metal (SR 400°C for 8 HRS)

Composite Wire	3 Layer Hardness HRC
HF-20	23-28
HF-30	30-40
HF-45	42-48
HF-55	52-54

**BASICITY INDEX** : 1.80-3.4  
**GRAIN SIZE** : -10+44 BSS  
**PACKAGING** : 25 kg. Bag  
**RE-DRYING CONDITIONS** : 300-350°C for 2 hours.

Manufactured By :

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