



"WELD WITH THE BEST"

SUBMERGED ARC WELDING FLUX

**SnFLUX™ 7X**

**Codification:** AWS: SFA 5.17 F7AZ-EL8, F7A0-EM12K

### Characteristics & Applications :

SnFLUX 7X is an acidic flux for single & multi-pass welding with single/multi-wires application in both AC & DC polarity up to 1\_2-1\_5 mtr/min. The benefits of this flux are the smooth surface finish and excellent slag detach ability. It is intended for a limited number of passes and plate thickness up to approx 20mm.

SnFLUX 7X is suitable for H/I-beam fabrication, water pipe welding, PEB structure, girder, wind mill tower, automotive industries etc.

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

Wire Grade	C	Mn	Si	S	P
SFA 5.17 EL-8	0.07	1.00	0.50	0.025	0.028
SFA 5.17 EM-12K	0.08	1.20	0.60	0.020	0.024

### Mechanical Properties of All-Weld Metal (Typical):

Wire Grade	YS MPa	UTS MPa	%EL (L=4d)	Impact, J at		
				RT	0°C	-20°C
SFA 5.17 EL-8	430	500	28	40	-	-
SFA 5.17 EM-12K	460	540	26	60	50	40

### Major Constituents:

SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CAF <sub>2</sub>
25%	5%	50%	15%

**BASICITY INDEX** : ~0.6  
**GRAIN SIZE** : 0.20-1.50 mm  
**PACKAGING** : 25 kg. Bag  
**RE-DRYING CONDITIONS** : 300-350°C for 2 hours before use.

Manufactured By :

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