

Codification: AWS: SFA 5.17 F7A6/P6-EH10K/EH12K

Characteristics & Applications:

SnFLUX 8(GLS) is a fluoride basic agglomerated welding flux having low diffusible hydrogen content designed for demanding application where radiographic weld quality, resistance to cracking and corrosion (NACE) are critical. It is particularly well-suited for offshore construction projects and other applications that require high-quality welds in challenging environments especially in stress relieving (SR) conditions.

SnFLUX 8(GLS) is neutral in Mn & Si pick up, suitable for single & multi-pass welding in HT Quenched & tempered steel, fine grained steels, and other heat resistant steels.

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

Wire Grade	C	Mn	Si	S	P
SFA 5.17 EH-10K	0.075	1.45	0.32	0.010	0.012
SFA 5.17 EH-12K	0.080	1.60	0.40	0.010	0.012

Mechanical Properties of All-Weld Metal (Typical):

Wire Grade	YS (Mpa)	UTS Mpa	EL (L=4d) %	CVN Impact, (J) at		
				-40°C	-51°C	-62°C
SFA 5.17 EH-10K (As Welded)	440	540	27	90	70	40
SFA 5.17 EH-10K (SR 620°C/2hr)	430	530	29	100	80	50
SFA 5.17 EH-12K (As Welded)	430	550	28	90	80	60
SFA 5.17 EH-12K (SR 620°C/2hr)	415	520	30	100	70	40

Major Constituents:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
10%	48%	17%	25%

BASICITY INDEX : ~3.4 | PACKAGING : 25 kg. Bag
GRAIN SIZE : 0.35-1.60 mm | RE-DRYING CONDITIONS : 300-350°C for 2 hours before use.