ENNATEK INDUSTRIES PVT. LTD.

"WELD WITH THE BEST"

SUBMERGED ARC WELDING FLUX

SnFLUX™ LAB-10

Codification: AWS: SFA 5.23 F8A6/P6-ENi3-Ni3, F8A6/P6-ENi2-Ni2, F11A6-EM4-M4, F9A4/P4-EF3-F3

Characteristics & Applications:

SnFLUX LAB-10 is a high basicity flux designed in combination with appropriate wires, such as Mo, Ni or Ni-Mo alloyed. The low impurities such as S and P and especially the low oxygen level after recommended re-drying in the weld metal gives high toughness at low temperature, uniform mechanical properties and crack resistance. It is suitable for welding on DC and Ac using single and tandem wire processes.

SnFLUX LAB-10 is suitable for welding in structural steels, pressure vessels steels, boilers, micro-alloyed steels, fine grained steels, petrochemicals where similar grade, of steel using like ASTM A203 Grade A/B/D/E, A537 Class 1 or 2, A537 Class 1 or 2, A514 or A517.

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

Wire Grade	C	Mn	Si	S	P	Cr	Ni	Mo
SFA 5.23 ENi3	0.08	1.20	0.28	0.010	0.016	0.05	3.0	-
SFA 5.23 ENi2	0.08	1.20	0.25	0.012	0.020	-	2.2	-
SFA 5.23 EM4	0.08	1.50	0.30	0.012	0.016	0.50	2.5	0.50
SFA 5.23 EF3	0.07	1.40	0.28	0.015	0.018	-	0.90	0.50

Mechanical Properties of All-Weld Metal (Typical):

Wire Grade	YS (Mpa)	UTS Mpa	% EL (L=4d)	CVN Impact, (J) at		
				-40°C	-50°C	-60°C
SFA 5.23 ENi3 (As-Welded)	540	640	25	-	70	40
SFA 5.23 ENi3 (SR 620°C/1hr)	500	600	27	-	80	50
SFA 5.23 ENi2 (As-Welded)	530	620	25	-	40	30
SFA 5.23 ENi2 (SR 620°C/1hr)	490	580	28	-	70	40
SFA 5.23 EF3 (As-Welded)	590	660	20	50	40	30
SFA 5.23 EF3 (SR 620°C/1hr)	570	640	22	60	50	40
SFA 5.23 EM4 (As-Welded)	720	800	17	-	50	40

Manufactured By :
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Major Constituents:

$SiO_2 + TiO_2$	$CaO + MgO$	$Al_2O_3 + MnO$	CAF_2
12%	42%	18%	28%

BASICITY INDEX : **About 3.0**
GRAIN SIZE : **0.35-1.60 mm**
PACKAGING : **25 kg. Bag**
RE-DRYING CONDITIONS : **300-350°C for 2 hours before use.**

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