



"WELD WITH THE BEST"

SUBMERGED ARC WELDING FLUX SnFLUX™ SB-4(Spl)

Codification: AWS: SFA 5.17 F7A4-EM12K, F7A4/P4-EH14, F7A4/P4-EH10K

Characteristics & Applications:

SnFLUX SB-4(Spl) is a Fluoride-basic type flux designed for application where high deposition rate as well as good slag removal is required this flux shows excellent weldability and weld bead appearance. The low hydrogen levels in the weld metal after recommended redrying gives good sub-zero impact properties & extreme resistance to cracking.

SnFLUX SB-4(Spl) is suitable for single & multirun welding of structural steels, pressure vessels steels, boilers, micro-alloyed (BIS:8500), fine grained steels and other fabrications involving medium tensile & low alloy steel.

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

Wire Grade	C	Mn	Si	S	P
SFA 5.17 EM-12K	0.07	1.10	0.28	0.022	0.026
SFA 5.17 EH-14	0.08	1.50	0.22	0.025	0.027
SFA 5.17 EH-10K	0.07	1.46	0.25	0.015	0.020

Mechanical Properties of All-Weld Metal (Typical):

Wire Grade	YS (Mpa)	UTS Mpa	EL (L=4d) %	CVN Impact, (J) at	
				-40°C	-46°C
SFA 5.17 EM-12K (As Welded)	410	515	29	40	-
SFA 5.17 EH-14 (As Welded)	428	540	29	46	30
SFA 5.17 EH-14(SR 620°C/1hr)	410	510	31	54	36
SFA 5.17 EH-10K (As Welded)	440	540	26	60	40
SFA 5.17 EH-10K (SR 620°C/1hr)	430	520	28	70	46

Major Constituents:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
20%	25%	20%	35%

BASICITY INDEX : ~1.8
GRAIN SIZE : 0.35-1.60 mm
PACKAGING : 25 kg.
RE-DRYING CONDITIONS : 300-350°C for 2 hours before use.

Manufactured By :

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