



"WELD WITH THE BEST"

# SUBMERGED ARC WELDING FLUX

## SnFLUX™ SB-4

**Codification:** AWS: SFA 5.17 F6A2-EL8, F7A4-EM12K, F7A4-EH14

### Characteristics & Applications:

SnFLUX SB-4 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 is suitable for single & multirun welding of structural steels, pressure vessels steels, boilers and other fabrications involving medium tensile & alloy steel.

### Typical all weld analysis, WT. %:

Details	C	Mn	Si	S	P	Cu
With EL8 Grade Wire	0.06	0.70	0.40	0.020	0.025	0.12
With EM-12K Grade Wire	0.07	1.00	0.50	0.020	0.028	0.14
With EH-14 Grade Wire	0.07	1.42	0.35	0.018	0.025	0.10

### Typical all weld mechanical properties:

Details	0.2 % YS (Mpa)	UTS Mpa	EL (L=4d) %	Impact, J at		
				-18°C	-29°C	-40°C
With EL8 Grade Wire	370	440	29	44	32	-
With EM-12K Grade Wire	410	510	26	60	50	30
With EH-14 Grade Wire	428	520	27	80	60	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>
20%	25%	20%	35%

BASICITY INDEX : ~1.6 | PACKAGING : 25 kg. Bag  
 GRAIN SIZE : 0.35-1.60 mm | RE-DRYING CONDITIONS : 300-350°C for 2 hours.

Manufactured By :

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