



"WELD WITH THE BEST"

SUBMERGED ARC WELDING FLUX

SnFLUX™ SS-4(LT)

Characteristics & Applications:

SnFLUX SS-4 (LT) is an agglomerated, Fluoride basic flux for welding of austenitic stainless steels, with AWS ER300 grade of wires. Especially recommended for the welding of stainless steels where good impact toughness at low temperatures is required, primarily for multi-run welding. The flux works very well on DC current, gives good slag detach ability and a smooth surface finish. The low ferrite content and low silicon content provides very good mechanical properties in the weld metal.

SnFLUX SS-4 (LT) can be used for chemical and petrochemical plants, power generation off shore construction, pressure vessels, storage tanks etc.

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

Wire Grade	C	Mn	Si	Cr	Ni	Mo	S	P
SFA 5.9 ER-308LER	<0.03	1.40	0.30	19.5	10.0	-	0.010	0.018
SFA 5.9 ER-309LER	<0.03	1.50	0.35	24.0	12.5	-	0.010	0.020
SFA 5.9 ER-316LER	<0.03	1.40	0.40	18.5	11.2	2.10	0.010	0.020

Mechanical Properties of All-Weld Metal (Typical):

Wire Grade	UTS Mpa	EL (L=4d) %	CVN Impact, J at		
			-60°C	-110°C	-196°C
SFA 5.9 ER-308LER	550	42	60	45	38
SFA 5.9 ER-309LER	570	36	70	50	34
SFA 5.9 ER-316LER	560	38	80	60	40

Major Constituents:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CAF ₂
20%	30%	20%	25%

- BASICITY INDEX** : ~2.0
GRAIN SIZE : 0.35-1.60 mm
PACKAGING : 25 kg. Bag
RE-DRYING CONDITIONS : 300-350°C for 2 hours before use.

Manufactured By :

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