

# ROFLX-10.62

GRAIN SIZE = 10X 60 BSS (0.25-1.60MM)

AWS: SFA/A 5.17 F7A4-EM12K

FLUORIDE-BASIC TYPE AGGLOMERATED  
SUBMERGED ARC WELDING FLUX

EN ISO 14174-A S FB 1 55AC H5

B.I. = 2.80-3.20

## KEY FEATURES:

ROFLX-10.62 Fluoride-Basic flux for suitable high strength fine grain structural steels, as well as cryogenic steels and steels of resistant to aging. Owing its natural behavior as regards pick-up and burn-out of Si and Mn, Neutral metallurgical behavior of this flux when the flux is weldable with almost every wire electrode. .

## APPLICATIONS

- tandem and multi-wire welding
- welding offshore compounds
- general structural steels, pressure vessels
- pipe steels
- fine grain steels

## RE-DRY CONDITION

- Re-drying recommended at 350°C for one hour before use.

## MAIN CONSTITUTION(%)

SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>
15	40	20	20

## CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-12K	0.080	1.20	0.15	0.011	0.016

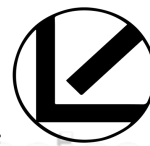
## MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	CHARPY "V" NOTCH IMPACT AT 0°C      -20°C	
ROSUB-12K	490	560	26	120 J	80 J

## WELDING POSITION



1G/1F



2G/2F

## PACKING SPECIFICATION

PACKED IN POLYTHENE-LINE PAPER BAGS OF 25.00 KG NET WEIGHT.