

# ROFLX-SPL

GRAIN SIZE = 8 X 60 BSS (0.25-2.00MM)

AWS: SFA/A 5.17/A5.23

HIGH -BASIC TYPE AGGLOMERATED SUBMERGED  
ARC WELDING FLUX

F8A4-F7A4-EM14 F7A2-EA2

B.I. = 2.20

## KEY FEATURES:

ROFLX-Spl an agglomerated Highly basic type submerged arc welding flux. It is used with operational properties for single double and multi wire system. It gives impact resistance subzero and minus temperature. The flux can be used with EL8, EM12K, EH14 and EA2

## APPLICATIONS

- fillet welding and single or multi pass butt welding with low, medium and high tensile steels
- Single wire tandem and multi-wire welding is possible for increased productivity

## 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	35	20	25

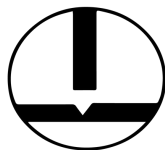
## CHEMICAL COMPOSITION:

UNDER Wires	C	Mn	Si	S	P
ROSUB-8	0.080	1.20	0.50	0.015	0.020
ROSUB-12K	0.070	1.40	0.40	0.018	0.022
ROSUB-14	0.11	1.70	0.25	0.012	0.015
ROSUB-A2	0.080	1.10	0.25	0.015	0.018/Mo-0.40

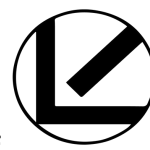
## MECHANICAL PROPERTIES

UNDER Wires	YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	CHARPY "V" NOTCH IMPACT AT JoulesTemperatures(°)	
ROSUB-8	400	500	25	45	-20
ROSUB-12K	450	580	26	50	-40
ROSUB-14	500	600	22	40	-40
ROSUB-A2	520	620	22	40	-20

## WELDING POSITION



1G/1F



2G/2F

## PACKING SPECIFICATION

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