UV C 418 TT

SAW flux, fluoride-basic type

Classification

EN ISO 14174

SA FB 1 55 AC H5

Characteristics and typical fields of application

UV C 418 TT is an agglomerated flux of fluoride basic type for joining and surfacing applications. Mainly for high strength and cryogenic fine grained structural steels.

It is characterized by its neutral metallurgical behaviour. Very good slag detachability. Excellent for narrow gap welding.

The flux can be used for tandem and multi wire welding with DC+ and AC.

Flux properties

Grain size (EN ISO 14174)	3 – 20 (0.3 – 2.0 mm)
Polarity	DC+ ; AC
Re-drying conditions	350°C, min 2 hrs ; max 3 cycles
Moisture content (AWS A4.4M: 2001)	≤ 0.10 % (as produced / re-dried)
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100gr (as produced / re-dried)

Typical Composition of sub-arc welding flux (weight %)

SiO_2+TiO_2	CaO+MgO	Al_2O_3+MnO	CaF_2	Basicity (Weight %)
16	33	20	27	2.5

Typical wire and flux combination

SAW wires	AWS A5.17 / A5.23	EN ISO 14171-A / 26304-A
T Union SA EM12K	F7A8/F6P8-EM12K	S 42 6 FB S2Si
Union S EM12K	F7A8/F6P8-EM12K	S 42 6 FB S2Si
T Union SA EH12K	F7A8/F7P8-EH12K	S 42 6 FB S3Si
Union S EH12K	F7A8/F7P8-EH12K	S 42 6 FB S3Si
T Union SA EH14	F7A8/F7P8-EH14	S 46 6 FB S4
Union S EH14	F7A8/F7P8-EH14	S 46 6 FB S4

Packaging formats

PLASTIC-BAG	25 kg / bag