

Classifications

EN ISO 14174

S F CS 2 DC

Characteristics and typical fields of application

Marathon 213 is a fused calcium silicate flux for submerged arc welding of standard stabilized and unstabilized CrNi(Mo) stainless steel grades. It is mostly applied for its very nice bead appearance without any slag residues. The flux can be applied in multi-pass and single pass welding procedures and for cladding. It provides a high degree of purity in the weld metal. The flux does not compensate chromium loss and is not hygroscopic.

Flux properties

Polarity	DC+. Tandem AC/DC+
Basicity index (Boniszewski)	1.3 (wt%)
Grain size (EN ISO 14174)	1 – 16 (0.1 – 1.6 mm)
Apparent density	1.5 kg/dm ³
Redrying	Mostly not necessary, however it can be redried at 100 – 150°C

Composition of sub-arc welding flux

	CaO+MgO+SiO ₂	CaO+MgO		
Gew. %	67	35		

Typical wires to combine

Name	EN ISO	Class	AWS / SFA	Class
Thermanit JE-308L	14343-A	S 19 9 L	A5.9 / -5.9	ER308L
Thermanit GE-316L	14343-A	S 19 12 3 L	A5.9 / -5.9	ER316L
Thermanit H-347	14343-A	S 19 9 Nb	A5.9 / -5.9	ER347
Thermanit A-318 (Thermanit A)	14343-A	S 19 12 3 Nb	A5.9 / -5.9	ER318
Thermanit 309L (Thermanit 25/14 E-309L)	14343-A	S 23 12 L	A5.9 / -5.9	ER309L

Packaging

Type	Weight
PE bag	25 kg