

Classifications

EN ISO 14174

S A GS 2 DC

Characteristics and typical fields of application

Marathon 801 is an agglomerated magnesium silicate flux for submerged arc welding with stainless steel wires. It can be applied for general purpose applications (joining and cladding). The flux provides chromium support to compensate chromium loss when welding. The weld metal for this reason typically has the same or somewhat higher chromium content than the wire itself. Recommended for joining (and cladding) with standard stabilized and unstabilized stainless steel grades. The flux provides very good welding properties / easy slag removal and gives a very nice bead appearance. Former product name was "Avesta Flux 801".

Flux properties

Polarity	DC
Basicity index (Boniszewski)	1.3 (wt%) ; 1.8 (mol)
Grain size (EN ISO 14174)	3 – 16 (0.3 – 1.6 mm)
Apparent density	1.0 kg/dm ³
Redrying	300°C – 350°C for 2 – 10 h

Composition of sub-arc welding flux

	Al ₂ O ₃	CaO + CaF ₂	MgO + SiO ₂
wt. %	15	13	58

Typical wires to combine

Name	EN ISO	Class	AWS / SFA	Class
Thermanit JE-308L (Avesta 308L/MVR)	14343-A	S 19 9 L	A5.9 / -5.9	ER308L
Thermanit 16/05 Mo (Avesta 248 SV)	14343-A	S 16 5 1	A5.9 / -5.9	-
Thermanit GE-316L (Avesta 316L/SKR)	14343-A	S 19 12 3 L	A5.9 / -5.9	ER316L
Thermanit H-347 (Avesta 347/MVNB)	14343-A	S 19 9 Nb	A5.9 / -5.9	ER347
Thermanit A-318 (Avesta 318/SKNb)	14343-A	S 19 12 3 Nb	A5.9 / -5.9	ER318
Thermanit 309L (Avesta 309L)	14343-A	S 23 12 L	A5.9 / -5.9	ER309L

Packaging

Type	Weight
DRY SYSTEM	25 kg