

Classifications

EN ISO 14174

S A MS 3

Characteristics and typical fields of application

RECORD R 250 is an agglomerated flux for cladding of non- and low-alloyed steel grades. Thanks to the addition of Cr and Mo, hardness levels of 250 - 300 HB can be achieved in combination with non-alloyed wires like Union S 2. Typical applications are crane wheels, shafts and constructional parts being exposed to compression.

Well suited for DC- and AC-processes.

Flux properties

Polarity	DC +/- AC-
Basicity index (Boniszewski)	0.63
Grain size (EN ISO 14174)	18-60
Apparent density	1.2
Moisture content (AWS A4.4M: 2001; 1050 °C)	<0.2

Composition of sub-arc welding flux

	CaO+MgO	CaF ₂	SiO ₂	FeO + MnO
wt. %	10	8	40	18

Typical wires to combine

Name	EN ISO	Class	AWS / SFA	Class
Union S 2	14171-A	S2	A5.17 / -5.17	EM12

Packaging

Type	Weight
bag	25 kg