

## Classifications

EN ISO 14174

S A FB 2

## Characteristics and typical fields of application

Record IND 24 is an agglomerated basic flux for submerged arc welding and cladding with stabilised and non-stabilised austenitic stainless steel wires as well as "duplex" and "superduplex" alloys stainless steel wires. Easy slag removal and good wetting properties.

## Flux properties

|   |                                    |
|---|------------------------------------|
| Polarity                                    | DC +/- / AC / max. 900 A           |
| Basicity index (Boniszewski)                | 2.2 (mole %)                       |
| Grain size (EN ISO 14174)                   | 4-14 (0.4–1.4 mm) ; (14 x 40 ASTM) |
| Apparent density                            | 1.0 kg/dm <sup>3</sup>             |
| Flux consumption                            | 0.65 ( kg fused flux / kg wire)    |
| Redrying                                    | 1 to 2 hours at 350 +/- 50°C       |
| Moisture content (AWS A4.4M: 2001; 1050 °C) | <0.2                               |

## Composition of sub-arc welding flux

|       | CaF <sub>2</sub> | Al <sub>2</sub> O <sub>3</sub> | SiO <sub>2</sub> |
|-------|------------------|--------------------------------|------------------|
| wt. % | 50               | 38                             | 10               |

## Packaging

| Type       | Weight |
|------------|--------|
| Metal drum | 25 kg  |