

Classifications

EN ISO 14174

S A FB 2

Characteristics and typical fields of application

RECORD IND 27 is an agglomerated fluoride-basic flux for Submerged Arc welding / cladding with stabilised and non-stabilised austenitic stainless steel wires.

- The flux contains a chromium support for effective counteraction to weld metal dilution and Cr burn-off in the first layer with 309L-wire and 309LMo(mod) –wire.
- Easy slag release and good wetting properties.
- Low hydrogen content and very low moisture pick up.

Flux properties

Polarity	DC +/- / AC 900 A max
Basicity index (Boniszewski)	2.2
Grain size (EN ISO 14174)	14-40
Apparent density	1
Flux consumption	1.2 (kg fused flux / kg wire)
Moisture content (AWS A4.4M: 2001; 1050 °C)	<0.2

Composition of sub-arc welding flux

	CaO+MgO	rest	Al ₂ O ₃	SiO ₂	TiO ₂	F-	FeO + MnO	K ₂ O + Na ₂ O
wt. %	30	9	30	7	-	20	4	2

Packaging

Type	Weight
Metal drum	25 kg