

## Classifications

EN ISO 14174

S A AB 2

## Characteristics and typical fields of application

Basic agglomerated flux designed for welding and cladding nickel alloys.  
Suitable for cryogenic steels applications: 5% & 9%Ni steels in combination with NiCr-3 & NiCrMo-3 wires.

## Flux properties

Polarity	DC +/- / AC (max. 800 A)
Basicity index (Boniszewski)	2.1 (mole %)
Grain size (EN ISO 14174)	0.4 - 1.4 mm ( 14 x 40 N° ASTM )
Apparent density	1.0
Flux consumption	1 ( 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

	CaO+MgO	rest	Al <sub>2</sub> O <sub>3</sub>	SiO <sub>2</sub>	TiO <sub>2</sub>	F-	FeO + MnO	K <sub>2</sub> O + Na <sub>2</sub> O
wt. %	35	-	45	6	-	10	-	2

## Packaging

Type	Weight
Metal drum	25 kg