

## Classifications

| EN ISO 14174 | Previous classification |
|--------------|-------------------------|
| S A FB 2     | S A AB 2                |

## Characteristics and typical fields of application

Highly basic agglomerated flux designed for welding and cladding of NiCr(Mo) alloys.  
Highly resistant against hot cracking thanks to its low level of Si pick up.

## Flux properties

|                              |                                |
|------------------------------|--------------------------------|
| Polarity                     | DC +/– / AC (max. 800 A)       |
| Basicity index (Boniszewski) | 2.8 (wt. %)                    |
| 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    |

## Composition of sub-arc welding flux

|       |
|-------|
| wt. % |
|-------|

## Typical wires to combine

| Name           | EN ISO | Class                      | AWS / SFA     | Class        |
|----------------|--------|----------------------------|---------------|--------------|
| UTP UP 068 HH  | 18274  | S Ni 6082 (NiCr20Mn3Nb)    | A5.14 / -5.14 | ER NiCr-3    |
| UTP UP 6170 Co | 18274  | S Ni 6617 (NiCr22Co-12Mo9) | A5.14 / -5.14 | ERNiCrCoMo-1 |
| UTP UP 776     | 18274  | Ni 6276 (NiCr15Mo-16Fe6W4) | A5.14 / -5.14 | ERNiCrMo-4   |
| UTP UP 6222 MO |        |                            |               |              |

## Packaging

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