

## Classifications

EN ISO 14174

SA AB 1 65 DC H5

## Characteristics and typical fields of application

Agglomerated flux of fluoride basic type for surface welding of unalloyed and low alloyed steels. Due to its neutral Si and Mn pick-up behaviour it is possible to apply the flux with different unalloyed and low alloyed sub arc wires within a large field of use. Very low carbon burn-off of weld metal.

If used in combination with corresponding wires it is possible to manufacture crack-free weld metal up to about 50 HRC.

Well suited for welding single and multi wire. Outstanding low consumption of flux and good slag detachability even at high interpass temperatures.

## Flux properties

Basicity index (Boniszewski)	2.9 Mol.-% / 2.2 Weight-%
Grain size (EN ISO 14174)	3 – 20 (0.3 – 2.0 mm)
Redrying	If transported and stored properly the flux can be used without redrying directly from the bag. Flux that has become humid should be redried for about 2 h at 350 – 400 °C (662 – 752 °F) prior to use.

## Composition of sub-arc welding flux

	SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>
wt. %	18	36	24	20

## Packaging

Type	Weight
Fass	200 kg
Sack	25 kg