UA 602

Classifications

EN ISO 14174

SA FB 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-out 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)	3.3 Mol.-% / 2.4 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 aout 2 h at 350 – 400 °C (662 – 752 °F) prior to use.

Composition of sub-arc welding flux

	SiO_2+TiO_2	CaO+MgO	Al_2O_3+MnO	CaF_2
wt. %	18	38	18	24

Packaging

Type	Weight
bag	25 kg