

Classifications
EN ISO 14174

S A FB 1 65 DC H5

Characteristics and typical fields of application

UV 420 TT-LH is an agglomerated flux of fluoride basic type characterised by the neutral metallurgical behaviour. In combination with suitable wire electrodes, the weld metal exhibits good toughness properties at low temperatures. For joining and surfacing applications with general purpose structural steels, fine grained structural steels and creep resistant steels. It is suited for single wire and tandem welding.

This flux has also been available on the market as "BÖHLER BB 24".

Flux properties

Polarity	DC
Basicity index (Boniszewski)	2.5
Grain size (EN ISO 14174)	3 – 25 (0.3 – 2.5 mm)
Flux consumption	1.0 kg flux per kg wire
Redrying	300 – 350 °C. 2 hrs min.
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100gr (as produced / re-dried)

Composition of sub-arc welding flux

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
wt. %	15	35	21	28

Typical wires to combine

Name	EN ISO	Class	AWS / SFA	Class
UNION S 3	14171-A	S3	A5.17 / -5.17	EH10
Union S 3 NiMo	14171-A	S3Ni1,5Mo	A5.23 / -5.23	EG
UNION S 4 MO	14171-A	S4Mo	A5.23 / -5.23	EA3
THERMANIT MTS 4	24598-A	S S CrMoWV12	A5.23 / -5.23	EG
UNION S 2 MO	14171-A	S2Mo	A5.23 / -5.23	EA2
UNION S 3 NIMO 1	26304-A	S3Ni1Mo	A5.23 / -5.23	EF3
UNION S 1 CRMO 5	24598-A	S S CrMo5	A5.23 / -5.23	EB6
UNION S 1 CRMO 5	24598-B	SU 5CM	A5.23 / -5.23	EB6
UNION S 3 Mo	14171-A	S3Mo	A5.23 / -5.23	EA4
UNION S 3 Mo	24598-A	S S MnMo	A5.23 / -5.23	EA4
UNION S 1 CRMO 2	24598-A	S S CrMo2	A5.23 / -5.23	EB3R
UNION S 2 NI 2,5	14171-A	S2Ni2	A5.23 / -5.23	ENi2
UNION S 2 CRMO	24598-A	S S CrMo1	A5.23 / -5.23	EB2R
Union S 2	14171-A	S2	A5.17 / -5.17	EM12

Packaging

Type	Weight
DRY SYSTEM	25 kg
PE-bag	25 kg