

Classifications

EN ISO 14174

S A AB 2

Characteristics and typical fields of application

Basic agglomerated flux designed for welding and cladding nickel alloys.

Flux properties

Polarity DC +/- / AC (max. 800 A)

Basicity index (Boniszewski) 1.6 (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 ₂ O ₃	SiO ₂	TiO ₂	F-	FeO + MnO	K ₂ O + Na ₂ O
wt. %	35	-	45	6	-	10	-	2

Packaging

Type	Weight
Metal drum	25 kg