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## REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. Approval statement added.

## GENERAL

Neutral, agglomerated, nickel- and molybdenum alloying flux, specially designed for strip cladding with a 17Cr-strip,

producing a weld metal with 14Cr-4Ni-1Mo and a hardness of 370-420 HB.

Can also be used for cladding with a 17Cr-wire producing the same weld metal.

## CLASSIFICATIONS Flux

EN ISO 14174      S A GS 3 Ni4 Mo1 DC

## APPROVALS

Not applicable

## SLAG TYPE

Calcium silicate SiO<sub>2</sub>-MgO-Al<sub>2</sub>O<sub>3</sub>-(CaF<sub>2</sub>)

## CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Ni	7	
Mo	2	
Al <sub>2</sub> O <sub>3</sub> +MnO	17	
CaF <sub>2</sub>	8	
CaO+MgO	28	
SiO <sub>2</sub> +TiO <sub>2</sub>	34	

## Other properties:

<b>Alloy Transfer</b>	Nickel and molybdenum alloying
<b>Basicity (Boniszewski)</b>	nom: 1.0
<b>Bulk Density</b>	nom: 1.0 kg/dm <sup>3</sup>
<b>Max Amperage Strip</b>	1000 A

## FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
26	0.65	
28	0.65	
<b>Current (A):</b>	750	
<b>Travel Speed (m/h):</b>	7	
<b>Dimension (mm):</b>	60 x 0.5	