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REASON FOR ISSUE

EN ISO 14174 classification and NAKS approval added.

GENERAL

High basic, all mineral, agglomerated flux designed for electro slag strip surfacing.

The flux is particularly suitable for strip cladding with stainless strip of the Cr-, Cr-Ni- and Cr-Ni-Mo-steel types, with or without Nb.

CLASSIFICATIONS Flux

EN ISO 14174 ES A FB 2B 56 44 DC

APPROVALS

NAKS/HAKC RD 03-613-03

APPROVAL COMMENT

All others: See Flux-Strip combinations

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Al ₂ O ₃	25
CaF ₂	63
SiO ₂ +MgO	8

Other properties:

Alloy Transfer	Moderately silicon alloying
Basicity (Boniszewski)	nom: 4.0
Bulk Density	nom: 1.0 kg/dm ³
Max Amperage Strip	1700 A (60 x 0.5 mm strip)

FLUX CONSUMPTION

	(kg Flux / kg Wire/Strip)	
Arc Voltage	DC+	AC
25	0.5	
Current (A):	1250	
Travel Speed (m/h):	9	

OTHER DATA

The flux is delivered in plastic-lined paperbags containing 25 kg.