



Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006021	Cancelling EN002612	Reg date 2013-04-04	Page 1 (1)
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REASON FOR ISSUE

EN ISO 14174 classification and approval statement added.

GENERAL

Very high basic agglomerated flux for electro slag strip cladding.

The flux has a low viscosity and is suitable for cladding with Ni base, Co and fully austenitic alloys due to its good wetting behaviour.

Also suitable for welding with higher travel speeds.

CLASSIFICATIONS Flux

EN ISO 14174

ES A FB 2B 56 44 DC

APPROVALS

Not applicable

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃	20	
CaF ₂	75	
SiO ₂ +MgO	5	

Other properties:

Alloy Transfer	Moderately silicon alloying
Basicity (Boniszewski)	nom: 5.4
Bulk Density	nom: 1.0 kg/dm ³
Max Amperage Strip	approx. 2500 (90 x 0.5 mm strip)

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
25	0.5	

OTHER DATA

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