

UV 420 TTRC

Fluoride basic type

Classifications

EN 760

SA FB 1 65 DC

Characteristics and field of use

UV 420 TTRC is an agglomerated fluoride-basic flux with high basicity and neutral metallurgical behavior. UV 420 TTRC is a special variant of flux UV 420 TTR. It supports the C-content of the wire electrode when DC-welding. In comparison with UV 420 TTR the C-content in the all weld metal is about 0.03-0.04% higher. It is suitable for multipass welding, for single and tandem-wire systems.

UV 420 TTRC has prime importance for SAW of the high-temperature resistant steel, for joining and surfacing applications.

Grain Size

EN 760: 3-20 (0.3-2.0 mm); Tyler Mesh: 8 x 48

Packaging

25 kg plastic bag, 200kg steel drum

Advice

Prior to use the flux should be redried for around 2 h at 300-350°C (572-662°F).

Main Constituents in %

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
15	35	21	26

Basicity (Boniszewski)

Mol.-%	Weight-%
3.4	2.5

Weld metal with	AWS A5.23	EN 14295
Union S 3 NiMo1	F10A6-EG-F3	S 62 6 F8 S3Ni1Mo