



## Submerged Arc Flux

### INCOFLUX® NT100 Submerged Arc Welding Flux

**INCOFLUX NT100 Submerged Arc Flux** is a neutral, agglomerated flux designed for wire welding with Nickel Filler Metal 61, INCONEL Filler Metals 82 and 625, NI-ROD 44 Filler Metal and NILO Filler Metals CF36 and CF42. Typical applications are groove welding Nickel 200 alloy to itself and to steels, and overlaying carbon steels with the Nickel 61 filler metal. The flux is also suitable to use with INCONEL Filler Metals 82 and 625 for overlaying and multi-pass welding. NI-ROD 44 Filler Metal and INCOFLUX NT100 are used to submerged arc weld cast irons to themselves and to steels. INCOFLUX NT100 is also used with NILO Filler Metal CF36 and CF42 to join Invar, NILO 36 and NILO 42.

**Welding Parameters:** Groove and Overlay Welding using DCEP current and Stringer beads.

Diameter	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Depth
0.062 in. 1.6 mm	250-280	28-30	10-12 in./min. 250-305 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	300-350	30-33	10-12 in./min. 250-305 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

**Overlay Welding with Oscillation:** Use DCEN current and Oscillation Frequency of 50-70 cycles / min for 0.062 in. and 35-50 for 0.093 in.

0.062 in. 1.6 mm	240-260	32-34	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	300-400	34-37	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

**Specification**  
EN 760 - S A AF2

**Particle Size**  
Tyler Sieves: 10 x 60 Mesh (0.25 mm x 2.0 mm), EN 760 2-20

**Packaging**  
50 pound (22.68 kg) Polyethylene Bucket with a hermetically sealed lid that has a rubber gasket seal.