Record IN

Flux for cladding

EN ISO 14174 : S A - AB 2

DESCRIPTION

- Agglomerated flux designed for sub-arc joining and cladding of non-stabilized stainless steel grades.
- Good slag removal, nice bead aspect.
- Suitable for “two-run” welding and fillet welds.

GENERAL CHARACTERISTICS

• Current	DC (+ and -) and AC – 900 A max.
• Basicity index	1.6 (according to Bonizewski; calculated in mole %)
• Grain size	0.4 – 1.4 mm (14 x 40 N° ASTM)
• Apparent density	0.95
• Consumption	0.7 (kg fused flux / kg wire)
• Redrying	1 to 2 hours at 350 +/- 50°C

TYPICAL WELD METAL ANALYSIS OF WIRE/FLUX COMBINATION (WEIGHT%)

Wire	ASME 5.9	EN ISO 14343-A	C	Mn	Si	Cr	Ni	Mo	Ferrite FN
Thermanit JE-308L	ER308 L	S 19 9 L	0.016	1.80	0.50	20.0	9.8	-	-
Weld metal			0.020	1.30	0.85	19.9	9.8	-	5
Thermanit GE-316 L	ER316 L	S 19 12	0.012	1.70	0.50	18.5	12.2	2.8	-
Weld metal		3 L	0.020	1.40	0.80	18.0	11.8	2.5	5

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	Rm [MPa]	Rp0.2 [MPa]	A5 [%]	Av [ISO – V]	
				-105°C	-196° C
Thermanit JE-308 L	580	400	38	55 J	40 J
Thermanit GE-316 L	570	365	38	-	40 J

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SUITABLE FOR

Alloyed metal	UNS	DIN	W. – Nr.	Wires: Thermanit JE-308 L	Wires: Thermanit GE-316 L
302	S30200	X12 CrNi 18 8	1.4300	x	-
304	S30400	X5 CrNi 18 10	1.4301	x	-
304L	S30403	X2 CrNi 18 11	14306	x	-
-	J92600	G – X6 CrNi 18 9	1.4308	x	-
304LN	S30453	X2 CrNiN 18 10	1.4311	x	-
(305)	J92701	G – X10 CrNi 18 8	1.4312	x	-
308	S30800	X5 CrNi 18 11	1.4303	x	-
304H	S30409	X6 CrNi 18 11	1.4948	x	-
321	S32100	X10 CrNiTi 18 9	1.4541	x	-
347	S34700	X5 CrNiNb 18 9	(1.4543)	x	-
-	S34700	X6 CrNiNb 18 10	(1.4550)	x	-
316	-	G – X5 CrNiNb 18 9	1.4552	x	-
316L	S31600	X5 CrNiMo 17 12 2	1.4401	-	x
-	S31603	X2 CrNiMo 17 13 2	1.4404	-	x
317L	J 92900	G – X6 CrNiMo 18 10	1.4408	-	x
317	S31703	X2 CrNiMo 18 16 4	1.4435	-	x
316Ti	S31700	X5 CrNiMo 17 13 3	1.4436	-	x
316Ti	S31635	X6 CrNiMoTi 17 12 2	1.4571	-	x
(318)	S31635	X10 CrNiMoTi 18 12	1.4573	-	x
(318)	S31640	X10 CrNiMoNb 18 12	1.4583	-	x
(318)	S31640	X5 CrNiMo 17 13	1.4449	-	x
(318)	S31640	G – X5 CrNiMoNb 18 10	1.4581	-	x

PACKING

25 kg (pail) : SAP stock number : 29069
25 kg (bag) : SAP stock number : 29070