

EN 760 : SA FB 2
 DIN 32522 : BFB 7 6434AC 8 3-16

DESCRIPTION

- Highly basic agglomerated flux designed for welding and cladding of NiCr(Mo) alloys.
- Highly resistant against hot cracking thanks to its low level of Si pick up.

GENERAL CHARACTERISTICS

- Current DC (+ and -) and AC – 800 A max
- Basicity index 5.1 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 1.0
- Consumption 1 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50°C

APPROVALS

Wires	TÜV Kennbl.-Nr.
Soudor NiCr 3	06540-03
Soudor 625 UP	04810-03

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

Wire Soudor	ASME 5.14	DIN 8556 / 1736	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Others
NiCr 3	ERNiCr-3	UP-NiCr20Nb	0.010	3.30	0.10	20.5	bal	-	2.4	0.8	Ti 0.35
All-weld metal			0.010	3.10	0.25	20.0	bal	-	2.2	0.8	Ti 0.15
625	ERNiCrMo-3	UP-NiCr21Mo9Nb	0.010	0.12	0.07	22.0	bal	9.0	3.6	0.4	Ti0.20
All-weld metal			0.015	0.20	0.25	21.5	bal	8.5	3.3	0.4	Ti 0.10
20.25.5 LCu	-	UPX2CrNiMoCu2025	0.015	1.80	0.40	20.0	25.0	4.5	-	-	Cu 1.5
All-weld metal			0.015	1.60	0.30	19.5	24.6	4.4	-	-	Cu 1.4
NiCrMo 59	-	Up-NiCr23Mo16	0.020	0.20	0.05	22.5	bal	16.0	-	0.25	-
All-weld metal			0.020	0.25	0.20	22.0	bal	15.5	-	0.25	-

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	Rm [MPa]	Rp0.2 [MPa]	A5 [%]	Av [ISO – V]	
				+ 20° C	-196° C
Soudor NiCr 3	600	370	40	120 J	100 J
Soudor 625	720	450	40	-	70 J
Soudor 20.25.5 LCu	540	340	42	100 J	-
Soudor NiCrMo 59	720	480	38	80 J	50 J

SUITABLE FOR

Alloyed metal	UNS	DIN	W. – Nr.	Wires			
				Soudor 20.25.5	Soudor NiCr 3	Soudor 625	Soudor NiCrMo 59
600	N06600	NiCr15 Fe	2.4640	-	x	x	-
601	N06601	NiCr23 Fe	2.4851	-	x	x	-
800	N08800	X10 NiCrAlTi32 20	1.4876	-	x	x	-
800H	N08810	X10 NiCrAlTi32 20	1.4958	-	x	x	-
75	N06075	NiCr20 Ti	2.4951	-	x	x	-
80A	N07080	NiCr20 TiAl	2.4952	-	x	x	-
90	N07090	NiCr20 Co18 Ti	2.4969	-	x	x	-
3% Ni	K81340	X8 Ni9	1.5662	-	x	x	-
625	N06625	NiCr 22 Mo9 Nb	2.4856	-	-	x	x
825	N08825	NiCr21 Mo	2.4858	-	-	x	-
317L	S31703	X2 CrNiMo 18 16 4	1.4438	x	-	-	-
317LN	S31753	X3 CrNiMoN 17 13 5	1.4439	x	-	-	-
-	-	G – X2 CrNiMoN 17 13 4	1.4446	x	-	-	-
-	-	G – X7 NiCrMoCuNb 25 20	1.4500	x	-	-	-
-	-	X5 NiCrMoCuNb 20 18 2	1.4505	x	-	-	-
-	-	X5 NiCrMoCuTi 20 18	1.4506	x	-	-	-
-	-	G – X2 NiCrMoCuN 20 18	1.4531	x	-	-	-
-	-	G – X2 NiCrMoCuN 25 20	1.4536	x	-	-	-
904L	S08904	X1 NiCrMoCuN 25 20 5	1.4539	x	-	-	-
59	N06059	NiCr23 Mo16 Al	2.4605	-	-	-	x
C4	N06455	NiMo16 Cr15 Ti	2.4610	-	-	-	x
C22	N06022	NiCr21 Mo14 W	2.4602	-	-	-	x
C276	N10276	NiMo16 Cr15 W	2.4819	-	-	-	x
-	-	NiCr20 Mo15	2.4811	-	-	-	x

PACKING

25 kg (pail) : SAP stock number : 29076