


Technical data sheet 011121MBA	FLUX WA ULTRAFLUX	 Welding Alloys
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CLASSIFICATION

EN ISO 14174 S A FB 1 55

DESCRIPTION

- Basic agglomerated all mineral flux for submerged arc cladding and hardfacing with cored wires
- Neutral action on weld metal chemistry
- Superior slag release properties maintained up to 450°C
- Good and smooth weld surface appearance with excellent wetting at the weld toes
- Suitable for single and multiple pass welding using single or twin arc techniques
- Appropriate for stringer or oscillating techniques
- Very suitable for hardfacing or cladding applications on caster rolls or on plates

CHEMICAL COMPOSITION

CaO + MgO + CaF ₂ + MnO	≥ 50 %
SiO ₂	≤ 20 %
CaF ₂	≥ 15 %

FLUX CHARACTERISTICS

Current type	DC+ or DC-
Granulometry	2.5 to 0.20 mm
Basicity index	2.4 - 2.6 according to Boniszewski
Re-drying	No re-drying required when the bag is unopened Flux that has become moist should be re-dried 2 to 4 hours at 300-350°C prior to use
Density	1.2 kg/dm ³

TYPICAL ALL-WELD METAL CHEMICAL COMPOSITIONS

	C	Mn	Si	Cr	Ni	Mo	Nb	V	N
HARDFACE BUF-S	0.15	1.3	0.8	1.5		0.5			
HARDFACE 350-S	0.15	1.5	0.8	2.2		0.2			
CHROMECORE 430-S	0.05	0.9	0.7	17.5					
CHROMECORE 434N-S	0.04	1.2	0.7	17.5	3.5	0.5			0.08
CHROMECORE 414MM-S	0.15	1.2	0.7	12.3	2.2	1.2	0.1	0.2	
CHROMECORE 414N-S	0.04	1.1	0.6	13.0	3.8	1.0			0.08
CHROMECORE 410-S	0.12	0.9	0.7	13.0					
CHROMECORE 420-S	0.30	1.0	0.7	13.0					
TUBE S 309L-S	0.02	1.4	0.7	24	13				
TUBE S 316L-S	0.02	1.6	0.6	20	12.6	2.7			

TYPICAL FLUX CONSUMPTION

Melted flux / kg wire:

26V:	0.7
29V:	0.9
32V:	1.1
35V:	1.3

PACKAGING

25 kg aluminium lined polyethylene moisture resistant bags.
Other packaging: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.