UP INOX C

Flux for Submerged Arc Cladding

Classification

ISO 14174: S A CS 2 5644 DC 2 - 20 EN 760: SA CS 2 DC

Charateristics

Agglomerated, neutral flux (without Cr–compensation) designed for Overlay Strip welding, hardfacing and joint cladding together with stainless strip of Cr–, CrNi(Mo)–steel types. Applicable for SAW–process as well as for use with Longer Stick Out cladding system which enables highest possible deposit rates as a result of the Joule heat (I^2R)–effect.

UP INOX C gives excellent slag removal without slag residuals, in the 1st layer on preheated substrates as well as in subsequent layers. The flux is less hygroscopic, hence gives low diffusible hydrogen, which makes it most suitable for overlay welding of heat resistant steels such as A387–types. Smooth weld bead appearance and notch–free weld overlay are features achievable with all cladding processes. Constant dilution rates can be achieved when using characteristic welding parameters. This flux shows constant chemical reactions as typical characteristics of a non–alloyed flux.

Applications

UP Inox C can be used for Joint Cladding, Surfacing and hardfacing, In combination with appropriate strip of EQ300/EQ400 (without Nb) series according to A5.9 or according to EN ISO 14343 (EN 12072) constant weld overlays are achievable. The flux is highly viscous and creates a reinforce-effect for the weld pool. This characteristic brings exceptional advantages by cladding low diameter-rolls.

Typical Flux Composition (%)

Cao+ MgO	CaF_2	SiO_2 + Al_2O_3+TiO_2	Basicity Index (Boniszewski)
30	15	50	~1.2

Other Properties

Density (Kg/dm^3(l)	Grain Size Acc. to ISO 14174	Current Carrying Capacity	Flux Consumption
1.0-1.1	2-20 (Tyler 8 x 65)	1500 A DC using one strip electrode 60 x 0.5 mm	~0.7 kg / kg Strip

Parameters

Strip (mm)	Polarity	Current (A)	Voltage (V)	Travel Speed (cm/min)
30 X 0.50	DC +	300 -430	28-30	9 – 15
60 X 0.50	DC +	650 - 850	28-30	9 – 15
90 X 0.50	DC +	1000 -1300	28-30	9 – 16

Packing & Storage

25 kg or others. The flux can be stored and used upto 3 years after delivery, subject to maintain the storage conditions. Flux that has picked up moisture has to be rebaked at ~ 300-350°C for ~ 4hrs before use. This flux is also available in 5kg **Ready to Use (RTU)** bag o n request.

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Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended.

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