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WELDING

SELECTARC UP LA04

Agglomerated Flux for Submerged Arc Welding

Classification

ISO 14174-A : SA AB 1 67 AC H5

Characteristics

Aluminate-Basic Agglomerated Flux for Submerged arc welding (SAW-Process) for joining welding of low alloy structural steels, Fine-grained steels and Pipe steel qualities. The flux shows constant metallurgical characteristics.

UP LA04 is formulated to achieve very low diffusible hydrogen levels, easy slag detachability, even in narrow groove welds or at high preheating temperature (> 250°C). Can be used on AC and DC welding, using with single and tandem wires.

Recommended Wires

Wire	AWS A5.17 / A5.23
S2	F6A4-EM12(K)
S3Si	F7P6-EH12K
S3	F7A4-EH10K
S2Mo	F8P4-EA2-A2
S2Ni1	F710-ENi1-Ni1
S2Ni2	F8P10-ENi2-Ni2
S3Ni1Mo	F9P8-EF3-F3
S2NiCu1	F8A4-EG-G
SCrMo1	F8P8-EB2R

Typical Flux Composition (%)

SiO_2+TiO_2	Al_2O_3 + MnO	CaO+MgO	CaF_2	Basicity according to Boniszewski
20 %	30 %	30 %	15 %	~ 1.70

Other Properties

Density (kg/dm³)	Grain size EN 760	Current - carrying capacity
1.1	3-20 ; Tyler : 8x48	Upto 1000 A (AC or DC) using one wire

Packaging & Storage

25 kg bag or others. The flux can be stored and used upto 3 years after delivery, subject to maintain recommended storage conditions. Flux that has picked up moisture has to be rebaked at ~ 350°C for ~ 2hrs before use.

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