Selectarc WELDING

SELECTARC UP LA05

Agglomerated Flux for Submerged Arc Welding

Classification

ISO 14174-A : SA FB 1 67 AC H5

Characteristics

Multipurpose semi-basic agglomerated Flux for submerged arc welding (SAW-Process). This flux is characterized by a low consumption rate, good welding properties over a wide range of parameters, excellent bead appearance and slag release, even in narrow gap welding. Low diffusible hydrogen level (<5 ml / 100g deposit). Low Si-pick up and slight – no Mn-pick up depending on the Mn-content of the wire.

Recommended Wires

Wire	AWS A5.17 / A5.23	ISO 14171A / 24598A
S2	F7A6 - EM12K	S 38 3 FB S2
S3	F6A6 - EH10K	S 42 3 FB S3
S2Mo	F8A5- EA2 - A2	S 46 3 FB S2Mo
S3Ni1Mo	F8P5 - EF1 - F3	S 50 3 FB S3Ni1Mo
S4Mo	F9A4 - EA3 - A3	S 55 3 FB S4Mo

Typical Flux Composition (%)

SiO_2+TiO_2	Al_2O_3 + MnO	CaO+MgO	CaF_2	Basicity according to Boniszewski
20%	30%	30%	17%	~ 1.7

Other Properties

Density (kg/dm^3)	Grain size EN760	Current - carrying capacity
0.95	2-16 : Tyler 10x65 2-20 : Tyler 8x65	1000A 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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