UTP UP FX 680

SAW flux

Classifications

EN ISO 14174

SF CS 2 DC

Characteristics and field of use

UTP UP FX 680 is a neutral, fused sub-arc welding flux of the calcium-silikate-type for joining and hardfacing of low-alloyed heat-resistant steels. It is a light basic type, has neutral metallurgical behaviour and provides excellent slag detachability. It is designed for use under direct current.

Chemical composition of the flux (guiding values) in %

CaF_2	CaO + MgO	Al_2O_3	SiO_2
20	35	5	30

Properties

- Basicity grade (according to Boniszewski) 1,3
- Grain size 0,1-1,6 mm (Tyler: 10 x 150)
- Flux consumption ~ 1 (kg flux / kg wire)
- If stored properly / for first use, the flux can be used without redrying directly from the bag. Flux that has become moist should be redried for about 2 hours at 300-350 °C prior to use.

Form of delivery

15 kg (bags)

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.