

Standards	EN 760	SA AB 1 76 AC H5
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Flux Type Aluminate-Basic

Characteristics Versatile flux for joint welding and surfacing with wire or strip electrodes. Suitable for high speed welding of butt and fillet welds with single and multi wire processes. Smooth weld bead appearance with flat weld interfaces free from undercut, self de-sludging without any slag residuals, high current carrying capacity and low flux consumption (wire/flux ratio 1: 0.8).. Uniform mechanical property performance and low diffusible hydrogen levels make it suitable for most of the SAW processes with its wide range of applications.

Applications Joint welding of non-alloy and low alloy structural steels, boiler steels, as well as fine-grain structural steels in combination with compatible wires. Surfacing with special hard facing wires and strips, including metal powder-cored wires

- Recommendations when hardfacing**
- **Cleaning:** remove rust, grease, oil and dirt before welding
 - **Surface preparation:** remove cracked, deformed and hardened surfaces by grinding or machining
 - **Deposit thickness:** avoid excessive build-up of hardfacing materials. Use buffering .layer materials before applying hardfacing deposits.
 - **Thermal history:** select appropriate preheat / interpass / soaking / PWHT according to the requirements.
 - **Welding procedure:** Use appropriate amperage (typical 130-140 A / each mm wire diameter) and voltage 27-30 V at travel speed about 40 ±5 cm / min and preheat / interpass temperature according to the substrate material requirement. Low but appropriate heat input keeps dilution rate low and improves hardfacing deposits

Main constituents	SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaO + MgO	CaF ₂
	30 %	30 %	25%	12%

Basicity according to Boniscewski: ~1,1

Flux density 0,95 kg/ dm³ (lt)

Grain size according to DIN EN 760: 2 – 20 (0,2 – 2,0 mm Tyler 8 x 65
4 – 30 (0,4 – 3,0 mm Tyler 6 x 35

Current-carrying capacity: 1.000 A (DC or AC / using one wire

Packaging: 25 kg PE- bags or 500-1250 kg Big-Bags

Storage and handling Flux can be stored up to 3 years in un-opened bag after delivery in dry storage. If, however, baking is necessary, flux should be baked at 175° ±25°C effective flux temperature.

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.