

Applications

Used for welding heat resisting alloys including Inconel 601, Incoloy 800/800H or combination of these with other alloys for furnace equipments, petrochemical plants and power generation plants.

Characteristics on Usage

- ① Superflux300 is an inert flux that composition of Si and Mn is hardly changed though welding condition is changed, and superflux300 is a bonded type flux and a high basicity flux. (the basicity of superflux300 is 2.7)
- ② Excellent arc stability and slag release.
- ③ Both its bead appearance and weldability are good.

Notes on Usage

- ① Dry the flux at 300~350°C (572~662°F) for 60 minutes before use.
- ② No preheat required and maximum interpass of 250°C(482°F). When welding superaustenitic alloys the interpass temperature should be controlled to a maximum of 100°C(212°F).

Welding Position

Current



1G
(PA)

AC or DC+

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb+Ta
0.023	0.44	0.40	0.003	0.002	21.0	61.8	9.0	3.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft · lbs)
715 (103,000)	37.7	-

Typical Welding Conditions (DC +)

Dia(mm)	Amp(A)	Vol(V)	Cpm(cm/min)	Remark
2.4	250~400			
3.2	300~450	28~36	30~60	
4.0	400~600			