

Superflux300 × SA-82

Applications

- ① Boilers of thermal power station and Offshore structures
- ② Superflux300 X SA-82 is for welding of a wide range of Ni based alloys and high temperature alloys.

Characteristics on Usage

- ① Superflux300 is a inert flux that composition of Si and Mn is hardly changed though wedling condition in chagned, and is a bonded type flux and a high basicity flux(The basicity of superflux300 is 2.7)
- ② Stable Arc and Slag Release, 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 Avoid using high current to prevent corrosion deterioration of HAZ and control Heat input as low as possible.
- ③ No preheat required and maxiumum interpass of 250°C(482°F). When welding super austenitic alloys, the interpass temperature should be controlled to maximum of 100°C(212°F).

Welding Position



1G
(PA)

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Ti
0.067	0.220	3.33	0.0001	0.014	19.66	69.88	0	0.119

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
619 (89,000)	46.4	-196 (-321)	117 (86)

Approval

I Packing

SA-82(Wire) : 25Kg Coil
Superflux300(Flux) : 20Kg Can