

FL 839

CATEGORY SAW Arc Submerged

TYPE Agglomerated high basic flux for SAW welding with Nickel based wires

APPLICATIONS Joining and cladding of: - Nickel-base alloys using NiCr- and NiCrMo- wire electrodes acc. to AWS A5.14 / EN ISO 18274 - Welding dissimilar steels such as low alloy steel with Nickel base alloys.

PROPERTIES High basic agglomerated welding flux - specially designed for a weight range of nickel alloys. This extra high basic flux produces smooth flat weld beads if appropriate welding parameters are used. The surface of the weld seam is free from slag inclusions and residues and is finely rippled. The metallurgical behavior of the flux is neutral (C-neutral, very low Si pick-up and low Mn burn-out) without Cr- or other alloy compensation. Due to the use of prefused raw materials the flux is able to produce extreme low P and S values in the weld deposit which reduces the risk of hot cracking when welding sensitive Ni-base alloys

Basicity: About 3.3 (according to boniszewski)
Current: DC+ by preference upto 600 Ampere (1 wire)
Grainsize Acc. DIN EN 760: 2-16

CLASSIFICATION EN ISO 14174: S A FB 2 DC
760: SA FB 2 DC

SUITABLE FOR Nickel based welding wires that are covered in AWS A 5.14 such as alloy 82, Inconel 600, 625, 601, 825, C276, alloy 59 etc.

APPROVALS CE approved

WELDING POSITIONS:



ANALYSIS ACCORDING EN ISO 15792-1:

With wire type	C	Si	Mn	Cr	Ni	Mo	Nb	Fe
SA Nicro 625	<0,04	<0,5	<0,5	20,0-22,50	Rem	8,5-9,5	3,0-3,5	<5,0

MECHANICAL PROPERTIES

AW with wire type	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-60°C	-196°C	
SA Nicro 625	>430	>700	>30	>70	>60	>32	

AW: as welded

WELDING PARAMETERS

D (mm)	Welding Parameters		
	Voltage (V)	Current (A)	Speed cm/min
1,6	26-27	250	50
2,0	27-28	300	50
2,4	27-28	360	50

REDRYING TEMPERATURE 350°C / 2hr

PACKING 15 kg PTFE perfectly sealed bags or 30 kg metallic sealed buckets.