

## FL X

**CATEGORY** SAW Arc Submerged

**TYPE** High basic SAW flux with very low hydrogen content and low X factor.

**APPLICATIONS** Drilling platforms, crane building, offshore fundamentals, jack ups, narrow gab welding, multi layer welding, Narrow gab, Creep resistant steels requiring low Bruscato factor, Nuclear applications

**PROPERTIES** Neutral high basic flux suitable for a weight range of wire combinations including multi layer welding in high demanding offshore applications because of its low hydrogen content and low Bruscato factor. The weld deposit shows extreme impact properties, excelent slag removal also in narrow gab and standard multi layer welding.  
 Basicity according to Boniszewski: 2,7  
 Grain size according DIN EN 760: 0,2-2,0 mm

**CLASSIFICATION** EN ISO 14174: SA FB 1 55 AC H5

**SUITABLE FOR** S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24, CrMo1, CrMo2, 13CrMo4-5, G17CrMo5-5, G22CrMo5-4, 10CrMo9-10, 12CrMo9-10, ASTM Grade A 387 Gr. 22

**APPROVALS** CE

**WELDING POSITIONS:**



**FLUX MAIN COMPONENTS % (TYPICAL)**

SiO <sub>2</sub> +TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	S	P
15	35	20	25	<0.015	<0.015

**MECHANICAL PROPERTIES**

with Wire	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
S3Si*	>460	530-680	>20			>47	
SACW 690*	>690	770-940	>17		>80	>69	
S2 CrMo1**	~480	~480	~22	110			
S2 CrMo2**	~590	~500	~22	100			
SA 90S-B9***	~560	~670	~20	50			

\* For both as welded condition and PWHT 580°C / 2hr. \*\* PWHT 670°C. \*\*\* PWHT 760°C.

**REDRYING TEMPERATURE** 300-350°C / 1-2hr

**PACKING** 25 kg sealed metal buckets / 25 kg bags.