WBSAWF-SSCR SUB ARC FLUX

Classifications	BS EN 14174 : S A AF 2 5644 DC H5 TUV /CE
Wire Specifications	WB308L-SAW : AWS A5.9 : ER308L WB253MA-SAW : AWS A5.9 : EG WB347H-SAW : AWS A5.9 : ER347H WB316L-SAW : AWS A5.9 : ER316L WB309L-SAW : AWS A5.9 : ER309L WB309LMo-SAW : AWS A5.9 : ER309LMo WB22-9-3L-SAW : AWS A5.9 : ER2209 WB25-9-3L-SAW : AWS A5.9 : ER2594
Product Description	WBSAWF-SSCR is an agglomerated, aluminate-fluoride-basic sub arc welding flux.
Applications	WBSAWF-SSCR can be used in combination with a wide range of austenitic and duplex stainless steels and Nickel base alloys. The flux is metallically neutral with no Cr compensation. The flux has been developed for welding with twin or multi-wire processes. The flux can be welded on DC and AC. Damp flux should be re-dried @ 300-350oC for 1 hour, prior to use. Basicity to Boniszewski : ~1.9 Packed in 25Kg plastic bags/drums

Main Constituents of flux	**SiO_2 + TiO_2**	**CaO + MgO**	**CaF_2**	**Al_2O_3 + MnO**
	10%	5%	50%	35%

Typical All-Weld Chemical Analysis	**C**	**Si**	**Mn**	**Mo**	**Cr**	**Ni**
WB308L-SAW	0.04	0.40	2.1	-	19.8	9.9
WB253MA-SAW (N 0.15)	.07	0.40	1.8	0.2	21.5	9.5
WB347H-SAW (Nb 0.6)	0.05	0.40	1.6	0.1	19.5	9.2
WB316L-SAW	0.03	0.35	1.5	2.1	18.2	11.1
WB309L-SAW	0.01	0.40	1.6	-	23.2	13.5
WB309LMo-SAW	0.01	0.40	1.6	2.8	23.2	13.5
WB22-9-3L-SAW (N 0.15)	0.04	0.35	1.8	3.1	23.4	9.2
WB25-9-3L-SAW (Cu 0.1, N 0.26)	0.02	0.35	0.6	3.8	25.2	9.4

Typical Mechanical Test Properties	**PWHT**	**UTS (N/mm2)**	**Yield (N/mm2)**	**El (%)**	**C-V (J)**
WB308L-SAW	As-welded	580	355	40	>47 (+20°C)
WB253MA-SAW	As-welded	645	440	36	>47 (+20°C)
WB347H-SAW	As-welded	660	450	40	>47 (+20°C)
WB316L-SAW	As-welded	560	380	35	>47 (+20°C)
WB309L-SAW	As-welded	580	360	31	>47 (+20°C)
WB309LMo-SAW	As-welded	720	540	29	>47 (+20°C)
WB22-9-3L-SAW	As-welded	730	510	24	>47 (+20°C)
WB25-9-3L-SAW	As-welded	830	630	24	>50 (-20°C)