

<b>Classification</b>				
<b>EN ISO 14174</b>				
SA AF 2 56 55 Mo DC				
<b>Characteristics and typical fields of application</b>				
<p>AVESTA C 805-D is an agglomerated flux of aluminate-fluoride-basic type. Flux 805-D is specially designed for joining duplex stainless steels but can also be used for austenitic stainless wires type 308L, 316L and 309L for applications where high corrosion resistance is required.</p> <p>The flux is alloyed with Cr and Mo which will improve the corrosion resistance. This makes it well suitable for surfacing. The alloy addition will cause a slight increase of the ferrite content (typically 2-3 %-units) compared to the wire.</p> <p>Very good welding properties and easy slag removal.</p>				
<b>Flux properties</b>				
Grain size (EN ISO 14174)		3 – 16 (0.3 – 1.6 mm)		
Polarity		DC+		
Re-drying conditions		350°C, min 2 hrs; max 3 cycles		
Moisture content (AWS A4.4M)		≤ 0.10 % (as produced / re-dried)		
Diffusible hydrogen (ISO 3690)		≤ 4 ml / 100gr (as produced / re-dried)		
<b>Typical Composition of sub-arc welding flux (weight %)</b>				
SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>	Basicity (Weight %)
10	0	40	50	1.8
<b>Typical wire and flux combination</b>				
<b>SAW wires</b>	<b>AWS A5.9</b>	<b>EN ISO 14343-A</b>		
AVESTA SA 2209	ER2209	S 22 9 3 N L		
AVESTA SA 308L	ER308L	S 19 9 L		
AVESTA S 308L S	ER308L	S 19 9 L		
AVESTA SA 316L	ER316L	- (Mo min 2.5% on request)		
AVESTA S 316L S	ER316L	- (Mo min 2.5% on request)		
AVESTA SA 309L	ER309L	S 23 12 L		
AVESTA S 309L S	ER309L	S 23 12 L		
<b>Packaging formats</b>				
PLASTIC BAG		25 kg / bag		