Avesta C 807

SAW flux, fluoride-basic

Classification
EN ISO 14174
SA FB 2

Characteristics and typical fields of application
AVESTA C 807 is specially designed for joining stainless steels which used for austenitic stainless wires type 308L, 316L and 309L for applications where high impact strength values and high corrosion resistance is required. It can also be used for cladding unalloyed or low-alloy steel Very good welding properties and easy slag removal.

Flux properties	
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)

Typical Composition of sub-arc welding flux (weight %)			
SiO_2+TiO_2	Al_2O_3	CaF_2	Basicity (Weight %)
10	38	50	2.3

Typical wire and flux combination		
SAW wires	**AWS A5.9**	**EN ISO 14343-A**
AVESTA SA 308L	ER308L	S (19 9 L)
AVESTA S 308L S	ER308L	S 19 9 L
AVESTA SA 316L	ER316L	S (19 12 3 L)
AVESTA S 316L S	ER316L	S 19 12 3 L
AVESTA SA 309L	ER309L	S (23 12 L)
AVESTA S 309L S	ER309L	S 23 12 L
AVESTA SA 347	ER347	S 19 9 Nb

Packaging formats	
PLASTIC BAG	25 kg / bag