Marathon 431

SAW flux, fluoride-basic, stainless steel

Classification	
EN ISO 14174	SA FB 2

Characteristics and typical fields of application

Marathon 431 is a fluoride-basic agglomerated flux for submerged arc welding of CrNi(Mo) stainless steel grades. The flux gives a nice bead appearance without any slag residues.

The flux can be applied in multi-pass and single pass welding procedures and has also very good welding properties in fillet welds.

It provides a high degree of purity in the weld metal and provides good mechanical properties with good corrosion resistance. The flux does not have a Cr-support.

Flux properties	
Grain size (EN ISO 14174)	4–14 and 3-16 (0.4–1.4 and 0.3-1.6 mm)
Polarity	DC+
Basicity (Boniszewski) wt%	2.2
Redrying conditions	300° - 350, min 2 hrs

Composition of sub-arc welding flux (weight %)		
SiO_2	Al_2O_3	CaF_2
10 %	38 %	50 %

Typical wires to combine		
SAW wires	**AWS A5.9**	**EN ISO 14343-A**
Thermanit JE-308L	ER308L	S 19 9 L
BÖHLER EAS 2-UP (LF)	ER308L	S 23 12 L
Thermanit GE-316L	ER316L	S 19 12 3 L
Thermanit H-347	ER347	S 19 9 Nb
Thermanit A	ER318	S 19 12 3 Nb
Thermanit 25/14 E 309L	ER309L	S 23 12 L
Thermanit 22/09	ER2209	S 22 9 3 N L
Thermanit 25/09 CuT	ER2594	S 25 9 4 N L

Packaging	
Type	**Weight (kg)**
PE-BAG	25
DRY SYSTEM	25
Metal can	30