

<b>Classification</b>			
<b>EN ISO 14174</b>		SA FB 2	
<b>Characteristics and typical fields of application</b>			
Marathon 444 is a highly basic agglomerated welding flux, designed for welding and cladding of NiCr(Mo) alloys. Highly resistant against hot cracking thanks to its low level of Si pick up.			
<b>Flux properties</b>			
Grain size (EN ISO 14174)		3 – 16 (0.3 – 1.6 mm)	
Polarity		DC+ , AC	
Basicity (Boniszewski) wt%		2.9	
Redrying conditions		300 – 350 °C / 2 hrs min.	
Apparent Density		1.0 kg/dm <sup>3</sup>	
<b>Composition of sub-arc welding flux (wt. %)</b>			
SiO <sub>2</sub> +TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> +MnO	CaO+MgO	CaF <sub>2</sub>
7	30	40	20
<b>Typical wires to combine</b>			
<b>SAW wires</b>	<b>AWS A5.14</b>	<b>EN ISO 18274</b>	
Thermanit Nicro 82	ERNiCr-3	S Ni 6082 (NiCr20Mn3Nb)	
Thermanit 625	ERNiCrMo-3	S Ni 6625 (NiCr22Mo9Nb)	
Thermanit Nimo C 276	ERNiCrMo-4	S Ni 6276 (NiCr15Mo16Fe6W4)	
<b>Packaging</b>			
<b>Type</b>	<b>Weight (kg)</b>		
DRY SYSTEM	25 kg		
Bucket	30 kg		