

Classification

EN ISO 14174

SA FB 1 65 DC H5

Characteristics and typical fields of application

UV 420 TT-LH is an agglomerated flux of fluoride basic type characterised by the neutral metallurgical behaviour. In combination with suitable wire electrodes, the weld metal exhibits good toughness properties at low temperatures. For joining and surfacing applications with general purpose structural steels, fine grained structural steels and creep resistant steels. It is suited for single wire and tandem welding.

Composition of sub-arc welding flux (wt. %)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
15	35	21	26

Flux properties

Grain size (EN ISO 14174)	3 – 25 (0.3 – 2.5 mm)
Basicity (Boniszewski) wt%	2.5
Polarity	DC+
Flux consumption	1 kg flux per kg wire
Redrying conditions	300 – 350°C, min 2 hrs
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100gr (as produced / re-dried)

Typical wires to combine

SAW wires	AWS A5.23	EN ISO 26304-A
Union S 2	S2	EM12
Union S 3	S3	EH10K
Union S 2 Mo	S2Mo	EA2
Union S 3 Mo	S3Mo	EA4
Union S 4 Mo	S4Mo	EA3
Union S 3 NiMo	S3Ni1,5Mo	EG [EF1 (mod.)]
Union S 3 NiMo 1	S3Ni1Mo	EF3
Union S 2 Ni 2,5	S2Ni2	ENi2
Union S 2 CrMo	S S CrMo1	EB2R
Union S 1 CrMo 2	S S CrMo2	EB3R
Union S 1 CrMo 5	S S CrMo5	EB6
Thermanit MTS 4	S S CrMoWV12	EG

Packaging formats

Type	Weight (kg)
DRY SYSTEM (bag)	25