



## SELECTARC UP WP 380A

Cr - Compensating  
Submerged Arc Welding Flux

### Classification

EN 760 : SA AF 2 DC

### Characteristics

Agglomerated Aluminate-Fluoride-Basic flux for submerged arc welding; Designed for joining and surfacing in combination with stainless steel and Nickel-base wires. Metallurgical behaviour of the flux: C-neutral, low Si pick-up and low Mn loss slight Cr compensation. Due to its high basicity, when welded with adapted wire electrodes diameters, crack free weld deposits are obtained with most stainless steel Cr-Ni and Cr-Ni-Mo grades.

#### Recommended Wires

AWS A5.9	ISO 14343A	AWS A5.9	ISO 14343A
ER 308L	S 19 9 L	ER 2209	S 22 9 3 N L
ER 347	S 19 9 Nb	ER 2594	S 25 9 4 N L
ER 316L	S 19 12 3 L		
ER 318	S 19 12 3 Nb		
ER 309L	S 23 12 L		

### Typical Flux Composition (%)

SiO <sub>2</sub> +TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> + MnO	CaO+MgO	CaF <sub>2</sub>	Basicity according to Boniszewski
7%	43%	5%	40%	~ 1.6

### Other Properties

Density	Grain size Acc. to EN 760	Current - carrying capacity
~ 1.0 kg/dm <sup>3</sup>	2 - 16 ; Tyler : 10x65	900 A, DC using one wire

### Packaging & Storage

25 kg bag or others. The flux can be stored and used upto 3 years after delivery, subject to maintain recommended storage conditions. Flux that has picked up moisture has to be rebaked at ~ 350°C for ~ 2hrs before use.