



## SELECTARC UP BF 10

Agglomerated Flux for  
Submerged Arc Welding

### Classification

ISO 14174-A : SA FB 1 55 AC

### Characteristics

Fluoride-Basic agglomerated Flux for submerged arc welding (SAW-Process) with a high basicity and low impurity levels such as P and S. As a result of low oxygen levels in the weld deposits uniform mechanical properties with high toughness values at low temperature are achieved. Because of almost neutral slag weld metal reactions the chemical analysis of the weld metal can be excellently controlled through the selection of appropriate wire electrodes. Can be used on AC and DC welding, using with single and tandem wires.

### Recommended Wires

Wire	AWS A5.17 / A5.23
S2	F7A8 - EM12K
S3	F7A8 - EH10K
S3Si	F7P8 - EH12K
S2Mo	F8A5 - EA2 - A2
S2Ni1	F7A10 - ENi1-Ni1
S2Ni2	F7P10 - ENi2-Ni2
S2Ni3	F8P15 - ENi3-Ni3
S3Ni1Mo	P9P8 - EF3-F3
SCrMo1	F8P8 - EB2R
SCrMo2	F8P0 - EB3R

### 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
15 %	20 %	40 %	25 %	~ 3.00

### Other Properties

Density (kg/dm <sup>3</sup> )	Grain size EN 760	Current - carrying capacity
0.95	2-20 ; Tyler : 8x65	Upto 800 A (AC or 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.

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