



SELECTARC UP Inox B

Flux for
Submerged Arc Cladding

Classification

EN 760 : SA CS 2 Cr

Characteristics

Agglomerated chromium compensating flux for submerged arc surfacing in combination with stainless steel strip electrodes.

AWS A5.9	EN 1.4343A
EQ 308L	S 19 9 L
EQ 347	S 19 9 Nb
EQ 316L	S 19 12 3 L
EQ 318	S 19 12 3 Nb
EQ 309L	S 23 12 L
EQ 2209	S 22 9 3 N L

Typical Flux Composition (%)

SiO ₂	Al ₂ O ₃	CaO+MgO	CaF ₂	Cr	Basicity according to Boniszewski
35%	15%	30%	7%	5%	~ 1.00%

Other Properties

Density	Grain size Acc. to EN 760	Current - carrying capacity	Flux consumption
~ 1.0 kg/dm ³	1 - 16	1200 A, strip 60x0.5 mm	0.7 kg / kg strip electrode

Alloying vectors

Strip	C	Si	Mn	Cr	Ni	Mo	Nb	N
EQ 308L	+ 0.002	+ 0.5	- 1.1	+ 0.3	- 0.2	0	0	+ 0.03
EQ 347	+ 0.004	+ 0.6	- 1.1	+ 0.3	- 0.2	0	-0.2	+ 0.03
EQ 316L	+ 0.002	+ 0.5	- 1.1	+ 0.4	- 0.2	0	0	+ 0.03
EQ 309L	+ 0.002	+ 0.6	- 0.9	+ 0.1	- 0.1	0	0	+ 0.03

Typical Chemical Composition of a 2 layer Cladding (%)

Strip	C	Si	Mn	Cr	Ni	Mo	Nb	N
UP309L+UP347	0.02	0.80	0.70	19.50	10.10	0.20	0.30	0.05

Parameters

Strip Electrode (mm)	Polarity	Current (A)	Voltage (V)	Travel speed (cm/min)
30 x 0.5	DC +	300 - 430	28 - 30	9 - 15
60 x 0.5	DC +	650 - 850	28 - 30	9 - 15
90 x 0.5	DC +	1000 - 1300	28 - 30	9 - 16

Packaging & Storage

25 kg bag or others. The flux can be stored and used upto 5 years after delivery, subject to maintain the recommended storage conditions. Flux that has picked up moisture has to be rebaked at ~ 350°C for ~ 4hrs before use.

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