



SELECTARC UP Inox L

Agglomerated Flux for
Submerged Arc Welding

Classification

ISO 14174-A : SA AF 2 64 AC H5

Characteristics

Agglomerated flux for submerged arc welding, designed for joint welding and surfacing in combination with stainless steel and nickel base wires. Easy slag release. Can be used on AC.

Recommended Wires

AWS A5.9	EN 1 4343-A	AWS A5.14	ISO EN 18274
ER 308L	S 19 9 L	ERNiCr3	S NiCr20Mn3Nb
ER 347	S 19 9 Nb	ERNiCrMo3	S NiCr22Mo9Nb
ER 316L	S 19 12 3 L		
ER 318	S 19 12 3 Nb		
ER 309L	S 23 12 L		
ER 2209	S 22 9 3 N L		

Typical Flux Composition (%)

Si	Al	Ca	K	Basicity according to Boniszewski
6.60%	20.50%	22.40%	1.70%	~ 1.60%

Other Properties

Density	Grain size Acc. to EN 760	Current - carrying capacity
~ 1.2 kg/dm ³	2 - 20	DC (+,-), AC , 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.