



UP LA 01

Agglomerated Submerge Arc welding Flux

Classification

ISO 14174: S A AR 1 76 AC H5 EN 760: SA AR 1 76 AC

Characteristics

The flux is suitable for high speed welding (up to 2 m/min.) and provides very good weld bead appearance and excellent slag release even with small angle preparation and fillet welds. The chemical nature of flux provides high resistance to cracking on single pass applications. Additional features are resistance to porosity when welding rusty plates, heavy scale or other contaminations of plate surfaces (e.g. special primer-coatings) and low sensitivity towards arc blow.

UP LA 01 is used for welding of ordinary carbon-manganese, low alloy structural and boiler quality steels with yield strength up to 355 MPa (t < 25 mm) in combination with low alloy grades such as Cr-Mo alloys.

Applications

UP LA 01 can be used used for single-run, two-run and fillet SA-welding. Main fields of application include structural steelwork, thin-walled containers, LP-gas cylinders and fin-tube walls.

Typical Flux Composition (%)

SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaO + MgO	CaF ₂	Basicity Index (Boniszewski)
25%	55%	5%	10%	~0.6

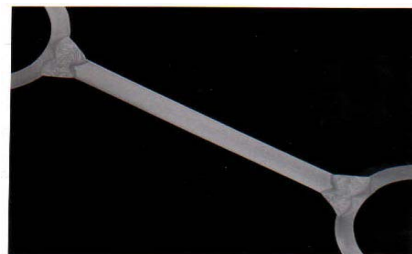
Other Properties

Density (Kg/dm ³ (l))	Grain Size Acc. to ISO 14174	Current Carrying Capacity
1.0	2-16 (Tyler 10 x 65)	up to 800 A (DC or AC) using one wire

Packing & Storage

25 kg or others. The flux can be stored and used upto 3 years after delivery, subject to maintain the storage conditions. Flux that has picked up moisture has to be re-baked at ~200 ± 50°C for 1-2hrs before use.

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Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended.

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