



## SELECTARC UP WP 380

### For High Alloyed Wires

#### Classification

ISO 14174-A : SF CS 2 5742 DC  
ISO 14174-A : SF CS 1 63 DC

EN 760

: SF CS 2DC H5

#### Characteristics

Flux designed for joint welding and surfacing in combination with stainless steel wire, also suitable for creep resistant Cr-Mo wires. The metallurgical behavior of the flux is neutral (C-neutral, low Si pick-up and low Mn loss, no Cr compensation). Due to the semi-basic flux characteristics crack free weld deposits are obtained with most stainless steel grades.

#### Recommended Wires

AWS A5.9	EN 1 4343-A	AWS A5.14	ISO 18274A
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	AWS A5.23	ISO 24598A
ER 309L	S 23 12 L	F7P0-EA2 - A2	S2Mo
ER 2209	S 22 9 3 N L	F8PZ- EB6 - B6	S1CrMo5
		F9PZ- EG-G	S2CrMoWV12

#### Typical Flux Composition (%)

SiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub>	CaO+MgO	CaF <sub>2</sub>	Basicity according to Boniszewski
30 %	5%	35%	20%	~ 1.30

#### Other Properties

Density (kg/dm <sup>3</sup> )	Grain size EN760	Current - carrying capacity
1.5	1-16 : Tyler 10x150	upto 900 A DC using one wire

#### Packaging & Storage

25 kg bag or others. The flux can be stored and use upto 5 years subject to maintain recommended storage conditions. Flux that has picked up moisture has to be rebaked at ~ 200-250°C for ~ 2 hrs before use.