



SELECTARC UP WP 380M

**Agglomerated Flux for
Submerged Arc welding**

Classification

EN 760 : SA AF 2 DC

Characteristics

Agglomerated Aluminate-Fluoride-Basic flux for submerged arc welding. Designed for joint welding and surfacing in combination with stainless steel and Nickel-base wires. The metallurgical behaviour of the flux is neutral (C-neutral, low Si pick-up and low Mn loss, without Cr compensation). Due to its high basicity, when welded with adapted wire electrodes diameters, crack free weld deposits are obtained with most stainless steel Cr-Ni and Cr-Ni-Mo grades.

Recommended Wires

AWS A5.9	ISO 14343A	AWS A5.9	ISO 14343A
ER 308L	S 19 9 L	ER 2209	S 22 9 3 N L
ER 347	S 19 9 Nb	ER 2594	S 25 9 4 N L
ER 316L	S 19 12 3 L		
ER 318	S 19 12 3 Nb	AWS A5.14	ISO 18274A
ER 309L	S 23 12 L	ERNiCrMo3	S Ni Cr 22Mo 9 Nb

Typical Flux Composition (%)

SiO ₂ +TiO ₂	Al ₂ O ₃ + MnO	CaO+MgO	CaF ₂	Basicity according to Boniszewski
10%	35%	5%	50%	~ 1.9

Other Properties

Density	Grain size Acc. to EN 760	Current - carrying capacity
~ 1.0 kg/dm ³	2 - 16 ; Tyler : 10x65	900 A, 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.