

<b>Classification</b>				
<b>EN ISO 14174</b>				
SA FB 1 56 AC H5				
<b>Characteristics and typical fields of application</b>				
<p>UV C 418 TT-M is an agglomerated flux of fluoride basic type for joining and surfacing applications. Mainly for high strength and cryogenic fine grained structural steels.</p> <p>Slightly pick-up Mn into the weld metal to give the weld joint higher strength and toughness.</p> <p>The flux can be used for tandem and multi wire welding with DC+ and AC.</p> <p>Very good slag detachability.</p>				
<b>Flux properties</b>				
Grain size (EN ISO 14174)		3 – 20 (0.3 – 2.0 mm)		
Polarity		DC+ ; AC		
Re-drying conditions		350°C, min 2 hrs ; max 3 cycles		
Moisture content (AWS A4.4M: 2001)		≤ 0.10 % (as produced / re-dried)		
Diffusible hydrogen (ISO 3690)		≤ 5 ml / 100gr (as produced / re-dried)		
<b>Typical Composition of sub-arc welding flux (weight %)</b>				
SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>	Basicity (Weight %)
15	32	20	28	2.5
<b>Typical wire and flux combination</b>				
SAW wires	AWS A5.17 / A5.23	EN ISO 14171-A / 26304-A		
Union CS EM12K	F7A8/F6P8-EM12K	S 42 6 FB S2Si		
Union CS EH12K	F7A8/F7P8-EH12K	S 46 6 FB S3Si		
Union CS 2 NiMo 1	F8A8-ENi1-Ni1	S 50 6 FB SZ2Ni1		
Union CS 2 Ni 2,5	F8A10-ENi2-Ni2	S 46 8 FB S2Ni2		
Union CS 3 NiMo 1	F9A6-EF3-F3	S 55 5 FB S3Ni1Mo		
Union CS 3 NiMoCr	F11A8-EG-G (EF6 mod.)	S 69 6 FB SZ3Ni2.5CrMo		
<b>Packaging formats</b>				
PLASTIC-BAG	25 kg / bag			