

Classifications
EN ISO 14174

S A FB 1 65 DC

Characteristics and typical fields of application

UV 420 TT is an agglomerated flux of fluoride basic type characterised by the neutral metallurgical behaviour. In combination with suitable wire electrodes, the weld metal exhibits good toughness properties at low temperatures. For joining and surfacing applications with general purpose structural steels, fine grained structural steels and creep resistant steels. It is suited for single wire and tandem welding.

Flux properties

Polarity	DC
Basicity index (Boniszewski)	2.5
Grain size (EN ISO 14174)	Standard 3 – 20 (0.3 – 2.0 mm) ; on request 3 – 25 (0.3 – 2.5 mm)
Flux consumption	1.0 kg flux per kg wire
Redrying	300 – 350 °C. 2 hrs min.

Composition of sub-arc welding flux

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
wt. %	15	35	21	26

Typical wires to combine

Name	EN ISO	Class	AWS / SFA	Class
Union S 3 NiMo 1	26304-A	S3Ni1Mo	A5.23 / -5.23	EF3
Union S 3	14171-A	S3	A5.17 / -5.17	EH10
Union S 3 NiMo	14171-A	S3Ni1,5Mo	A5.23 / -5.23	EG
Union S 4 Mo	14171-A	S4Mo	A5.23 / -5.23	EA3
Union S 2 Mo	14171-A	S2Mo	A5.23 / -5.23	EA2
Union S 3 Mo	14171-A	S3Mo	A5.23 / -5.23	EA4
Union S 3 Mo	24598-A	S S MnMo	A5.23 / -5.23	EA4
Union S 2 Ni 2,5	14171-A	S2Ni2	A5.23 / -5.23	ENi2
Union S 2	14171-A	S2	A5.17 / -5.17	EM12
Union S 2 CrMo	24598-A	S S CrMo1	A5.23 / -5.23	EB2R
Union S 1 CrMo 5	24598-A	S S CrMo5	A5.23 / -5.23	EB6
Thermanit MTS 4	24598-A	S S CrMoWV12	A5.23 / -5.23	EG

Packaging

Type	Weight
Metal bucket	30 kg
PE-bag	25 kg