

❖ Product Description

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| I. Agglomerated fluoride basic type of flux | V. Current type DCEP/AC |
| II. Extra high basic flux having basicity index 3.1 | VI. Comes with grain size ranges from 0.25-2.0mm |
| III. Suitable for Stainless Steel | |
| IV. Give better results for speeds between 0.4-0.6 m/min | |

❖ Range of Application

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| I. Most suitable for cryogenic application | II. Welding of austenitic, duplex and super duplex stainless steel |
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❖ Classification

Compatible with 308L, 309L, 316L, 347, 2209 & 2594 grades

❖ % Chemical Composition of Weld Deposits (weight %)

With Grade	C	Mn	Si	Ni	Cr	Mo
308L	0.025	1.40	0.50	19.5	9.3	-
309L	0.025	1.40	0.50	23.5	12.5	-
316L	0.025	1.40	0.50	18.5	11.5	2.3
347	0.050	1.40	0.50	19.5	9.5	-
2209	0.025	1.30	0.50	22	9	3
2594	0.025	0.6	0.50	25	7	3.5

❖ Chemical Composition of Flux (% wt)

	SiO ₂ +TiO ₂	Al ₂ O ₃ + MnO	CaF ₂
Typical Values	15%	35%	50%

❖ Packaging

Available in 25 kg HD Poly lined Bag

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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