

FL 160F

CATEGORY	SAW Submerged arc
TYPE	High basic SAW flux with low hydrogen content.
APPLICATIONS	Boiler works, vessel and structural steel works, tanks and pressure vessels, offshore lifting applications, platforms etc..
PROPERTIES	<p>Agglomerated Basic flux suitable for carbon and low alloyed steel welding. The weld deposit produced in combination with corresponding sub-arc wires meets outstanding mechanical properties and in particular high toughness at extreme sub zero temperatures. Excellent slag removal in fillet and groove welds even in hot condition (In root passes slag release will improve by degreasing the voltage). Excellent bead aspect, even in fillet welds.</p> <p>Basicity: About 3 (according to boniszewski) Current: DC or AC, in single or multi-wires Grain size: According to EN 760: 2-20 specification</p>

CLASSIFICATION	AWS	5.17: F7AP8-EH12K 5.17: F7AP6-EH14 5.17: F7AP6-EA3-A3
	EN ISO	14174: SA FB 1 55 AC H5
	DIN	BFB 155ACAC10MHVP5

SUITABLE FOR	S355, S420, S460, X65, X70, X80
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APPROVALS	CE approved
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WELDING POSITIONS:	
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NOMINAL FLUX COMPOSITION %	CaO+MgO	FeF ₂	Fe ₂ O ₃	SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	P ₂ O ₅	CaF ₂
	40			15	20		25

MECHANICAL PROPERTIES	With Wire type	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
					+20°C	-40°C	-60°C	
	S2(Si)	>430	>540	>21		>47		
	S3Si	>460	>550	>20		>47		
	S2Mo	>460	530-680	>19		>47		
	S2CrMo1	430-510	530-610	21-25	>60			

The above figures are valid for the as welded condition.

REDRYING TEMPERATURE	350C / 2hr to obtain 5 ml/100 gr. max.
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PACKING	Plastic bags 25 kg, 200 kg steel drums and 500-1000 kg big bags
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