Technical data sheet 0801221MBA	FLUX **WAF 385**	Welding Alloys

CLASSIFICATION

EN ISO 14174-A: S A AF 2 64 AC H5

DESCRIPTION

- WA FLUX 385 (WAF 385) is a basic agglomerated flux for submerged arc welding and cladding of corrosion resistant materials with cored wires
- Neutral action on weld metal chemistry
- Easy slag removal, even in narrow preparations
- Good surface appearance with excellent wetting at the weld toes
- Suitable for:
  - ✓ stabilised and non-stabilised austenitic stainless steels
  - ✓ superaustenitic stainless steels
  - ✓ duplex and superduplex stainless steels
  - ✓ nickel based alloys

CHEMICAL COMPOSITION

Al_2O_3	38%
CaO	14%
CaF_2	30%
SiO_2	17%

FLUX CHARACTERISTICS

Current type	DC+, DC- or AC.
Granulometry	2 - 20 (0.2 – 2.0 mm according to ISO 14174).
Basicity index	1.6 according to Boniszewski
Re-drying	the flux can be stored up to three years in a dry room. If the flux has taken up moisture, it is recommended to dry it at 350-400°C during minimum one hour
Flux consumption	0.7 kg fused flux / kg wire.

PACKAGING

25 kg aluminium lined polyethylene moisture resistant bags.
Other packaging: please consult us