

**Technical  
data sheet**

080122MBA

FLUX

**WA FLUX 415****CLASSIFICATION**

EN ISO 14174: S A FB 1 55 DC H5

**DESCRIPTION**

- WA FLUX 415 (WAF 415) is a basic agglomerated flux for submerged arc hardfacing
- Neutral action on weld metal chemistry.
- Outstanding slag detachability

**CHEMICAL COMPOSITION**

CaF <sub>2</sub>	20 %
SiO <sub>2</sub> + TiO <sub>2</sub>	20 %
CaO + MgO	35 %
Al <sub>2</sub> O <sub>3</sub> + MnO	23 %

**FLUX CHARACTERISTICS**

Current type	DC
Granulometry	3-20 (8 x 48 Tyler mesh)
Re-drying	If stored properly the flux can be used without re-drying directly from the bag. Flux that has become moist should be re-dried at around 2h at 300-350°C prior to use.

**PACKAGING**

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