MF 600

SAW Cladding Flux

Flux type: **F**luoride-**B**asic

Classification: ISO 14174 – **ES A FB 2B 5644 DC**
(EN 760 – **SA FB 2 DC**)

Characteristics:
High basic, agglomerated, neutral flux (without alloy–compensation) designed for overlay welding and joint cladding together with nickel base strip electrodes of the NiCr(Mo)–steel types like 625 and 82.
MF 600 gives excellent slag removal without slag residuals, in the 1st layer on preheated substrates as well as in subsequent layers when joint cladding. The flux has low hydrogen potential, which makes it most suitable for overlay welding of heat resistant steels such as A387–types.

Applications :
MF 600 can be used for joint cladding and surfacing of chemical plant components and equipments in the nuclear/off- shore fields to obtain hogh NiCr(Mo)-overlays such as Alloy 600, Alloy 625 and similar alloys such as Alloy 59 and C276).

Typical chemical analysis of flux:

$SiO_2 + Al_2O_3 + TiO_2$	CaO + MgO	CaF_2
20 %	5 %	70 %
Basicity according to Boniszewski: ~4.6		

Flux density: 1.0 – 1.1 kg/dm³ (l)

Grain size acc. to ISO 14174: 2 – 16 (Tyler 10 x 65)

Current-carrying capacity: up to 1,500 A DC using one strip electrode 60 x 0.5 mm

Packaging: 25 kg PE-coated Aluminium bags

Storage and redrying:
Unopened originally packed flux bags can be stored up to 1 year in dry storage rooms after date of delivery ex factory.
Redrying conditions specific to the flux: 300 – 350 °C effective flux temperature.