

## Classification

EN ISO 14174

SA CS 2 CR DC

## Characteristics and typical fields of application

Avesta Flux 801 is a neutral chromium compensated agglomerated flux. It is a general-purpose flux, designed both for joining and cladding of un-alloyed and low-alloyed steels. Flux 801 can be used in combination with all types of stabilised and non-stabilised Cr-Ni and Cr-Ni-Mo filler metals. It provides a smooth weld surface, very good welding properties and easy slag removal.

It is Cr-alloyed to compensate losses during welding.

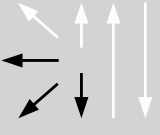
## Base materials

Suitable for welding of many stainless steels together with SAW wire Avesta 308L/MVR, 347/MVR, 316L/SKR, 318/SKNb, 309L and P5

## Composition of sub-arc welding flux (wt. %)

	SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub>	CaF <sub>2</sub>
wt.-%	20	26	18	32

## Operating data

	<b>Polarity:</b> DC ( + ) / DC ( - )	<b>Basicity index Boniszewski:</b>	1.0 Gew. %
		<b>Bulk density:</b>	0.8 kg/dm <sup>3</sup>
		<b>Grain size acc. to EN ISO 14174:</b>	2 – 12 (0.2 – 1.25 mm)
		<b>Flux consumption: (26 V)</b>	0.4 kg Flux per kg wire
		<b>(34 V)</b>	0.7 kg Flux per kg wire
		<b>Re-drying:</b>	250 – 300 °C, min. 2h

## Typical composition of all-weld metal with different wires

Wire	C	Si	Mn	Cr	Ni	Mo	FN (DeLong)
Avesta 308L/MVR	0.02	0.9	1.0	20	9.5	-	13
Avesta 316L/SKR	0.02	0.9	1.0	19.0	12.0	2.6	13

wire	Classification of the wire/flux-combination	
	acc. to EN ISO 14343-A	acc. to AWS A5.9
Avesta 308L/MVR		
Avesta 347/MVR		
Avesta 316L/SKR		
Avesta 318/SKNb		
Avesta 309L		
Avesta P5		

## Approvals

Wire/flux combination Avesta Flux 801 together with Avesta wires:

**TÜV, CE:** Avesta 308L/MVR, Avesta 347/MVR, Avesta 316L/SKR, Avesta 318/SKNb

**DNV:** Avesta 308L/MVR, Avesta 316L/SKR, Avesta P5, Avesta P7