Record CuAlW

Flux for cladding

EN 760 : SA AB 2

DESCRIPTION

- Agglomerated flux for joining CuAl alloys and for surfacing on steel with CuAl wires (as Soudor CuAl 8).
- The deposit shows a good resistance to seawater, acid and basic solutions, cavitation and metal to metal wear.

GENERAL CHARACTERISTICS

- Current: DC +
- Basicity index: 2.5 (according to Bonizewski; calculated in mole %)
- Grain size: 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density: 1
- Consumption: 0.9 (kg fused flux / kg wire)
- Redrying: 1 to 2 hours at 350 +/- 50°C

TYPICAL WELD METAL ANALYSIS OF WIRE/FLUX COMBINATION (WEIGHT%)

- Base metal : 0.2% C - steel
- Deposit : 4 layers
- Preheat and interpass temperatures : 150 – 200°C
- Welding parameters : ø 4.0 wire : 400 A – 30 V – 40 cm/min
  ø 1.6 wire : 300 A – 30 V – 35 cm/min

Wire	Layer	C	Mn	Si	Al	Fe	Cu	Hardness
Soudor CuAl 8 [ø 4.0]	-	<0.01	0.20	0.2	8.7	0.2	balance	-
	1	0.095	1.10	0.75	5.1	32	balance	180 HB
	2	0.030	1.0	0.70	7.0	10	balance	145 HB
	3	0.01	0.7	0.60	7.5	3	balance	135 HB
Soudor CuAl 10 [ø 1.6]	-	0.006	0.005	0.04	9.6	1.08	balance	-
	1	0.052	0.61	0.21	6.0	24.5	balance	184 HB
	2	0.041	0.46	0.21	7.0	12.1	balance	167 HB
	3	0.024	0.35	0.19	7.6	5.5	balance	148 HB
	4	0.025	0.30	0.17	7.9	3.5	balance	135 HB

PACKING

25 kg (pail) : SAP stock number : 29172

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.