

<b>Classification</b>			
<b>EN ISO 14174</b>		SA FB 1 65 DC H5	
<b>Characteristics and typical fields of application</b>			
<p><b>UTP RECORD 605</b> is an agglomerated flux for submerged arc welding. It is recommended for surfacing application especially with different unalloyed and low alloyed SAW wires. It has neutral metallurgical behaviour and provides excellent slag detachability even at high interpass temperatures. Suited for welding with single and multi-wire configurations. The flux is mostly applied with solid and with flux-cored wires for hard-facing applications up to hardness up to 50HRC.</p>			
<b>Flux properties</b>			
Grain size (EN ISO 14174)		3 – 20 (0.3 – 2.0 mm)	
Polarity		DC+	
Basicity (Boniszewski) wt%		2,1	
Redrying conditions		300 – 350 °C / 2 hrs min.	
Apparent Density		1.0 kg/dm <sup>3</sup>	
<b>Composition of sub-arc welding flux (wt. %)</b>			
SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>
20	35	16,5	23
<b>Typical wires to combine</b>			
<b>SAW wires</b>			
SUBARC T55 HP	SK 219 – S	SK A43 – S	SK 461C – SA
Union S 2 Mo	SK AP – S	SK A45 – S	SK 740 – SA
UTP UP 73 G 2	SK 402 – S	SK Tool Alloy C-S	SK 410NiMo - SA
UTP UP 73 G 3	SK 258 – SA	SK 410 – SA	SK D35 – S
UTP UP 73 G 4	SK 258L – SA	SK 415 – SA	SK 742N-SK
UTP UP DUR 250	SK 258NbC-SA	SK 420 – SA	SK Stelkay 6 - G
UTP UP DUR 350	SK 255 – S	SK 430C – SA	SK Stelkay 21 - G
<b>Packaging</b>			
Type	Weight (kg)		
PE-bag	25 kg		