

Classification

EN ISO 14174

SA AB 1 67 AC H5

Characteristics and typical fields of application

UV C 401 is an agglomerated flux of aluminate-basic type for joining and surfacing applications with general-purpose structural steels, boiler and pipe steels.

The flux is characterized by low Silicon and Moderate manganese pick-up.

The welding characteristics are good producing a smooth weld bead with excellent slag detachability.

Flux properties

Grain size (EN ISO 14174)	3 – 20 (0.3 – 2.0 mm)
Polarity	DC+, AC
Re-drying conditions	350°C, min 2 hrs; max 3 cycles
Moisture content (AWS A4.4M: 2001)	≤ 0.10 % (as produced / re-dried)
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100 g (as produced / re-dried)

Typical Composition of sub-arc welding flux (weight %)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂	Basicity (Weight %)
19	31	29	20	1.7

Typical wire and flux combination

SAW wires	AWS A5.17	EN ISO 14171-A
T Union SA EM12K	F7A4/F6P5-EM12K-H5	S 42 4 AB S2Si
Union EM12K	F7A4/F6P5-EM12K-H5	S 42 4 AB S2Si
T Union SA Ni1	F8A8-ENi1-Ni1-H5	S 46 4 AB SZ 2Ni1

Packaging formats

Plastic bag	25 kg / bag
Big bag	1,000 kg / bag