Marathon 213

SAW flux, fused, stainless

Classification
EN ISO 14174
SF CS 2 DC

Characteristics and typical fields of application
Marathon 213 is a fused calcium silicate flux for submerged arc welding of CrNi(Mo) stainless steel grades. The flux gives a very nice bead appearance without any slag residues. The flux can be applied in multi-pass and single pass welding procedures. The flux provides a high degree of purity in the weld metal and provides good mechanical properties with good corrosion resistance. The flux does not have a Cr-support.

Flux properties	
Grain size (EN ISO 14174)	1-16 (0.1–1.6 mm)
Polarity	DC+ ; and tandem DC+ / AC
Basicity (Boniszewski) wt%	1.3
Redrying conditions	100°C – 200°C (not necessary for stainless steel)
Apparent Density	1.5 kg/dm3

Composition of sub-arc welding flux (weight %)			
SiO_2+ TiO_2	CaO + MgO	Al_2O_3 + MnO	CaF_2
30 %	35 %	5 %	20 %

Typical wires to combine		
SAW wires	**AWS A5.9**	**EN ISO 14343-A**
Thermanit JE-308L	ER308L	S 19 9 L
Thermanit GE-316L	ER316L	S 19 12 3 L
Thermanit H-347	ER347	S 19 9 Nb
Thermanit A	ER318	S 19 12 3 Nb
Thermanit 25/14 E 309L	ER309L	S 23 12 L

Packaging	
Type	**Weight (kg)**
PE-BAG	25 kg