

AI-16601

Specifications

NB/T47018.4-2011

Description and Applications

AI 16601 is a submerged arc flux designed for joining/cladding of stainless steels and low alloy surfacing consumables.

Typical Flux Analysis

SiO ₂ +TiO ₂	MnO+Al ₂ O ₃	CaF ₂	S	P	H ₂ O	Impurities
5-10%	30-40%	40-50%	0.017	0.018	0.03	0.04

Analysis of Deposited Weldmetal [H08Cr21Ni10 (308L)]

C	Mn	Si	Cr	Ni	S	P
0.08	1.52	0.52	19.5	9.6	0.020	0.019

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	575MPa
Elongation	>43.2% (5d)
Flux particle size	10-60 mesh

Welding Instructions

Prior to welding flux needs to be baked for approximately 2 hours at 300-350°C

Ensure all surface contamination, rust, mill scale, etc. is blasted/grounded prior to welding

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

