XUN-225 Agglomerated Flux for S.A. Welding

Specification： EN760 AWS A5.17/A5.23
Classification SA FB 1 55 AC H5 F8P0-EB2-B2
F8P2-EB3-B3

Characteristics： XUN-225 is an agglomerated fluoride-basic type flux with high basicity

Grain size: 10 to 60 mesh.
Metallurgical behavior: Low silicon pick-up and the behavior of manganese is neutral.
Grain size: 10 - 60 mesh.
Basicity: 2.4 (BIIW).
Diffusion hydrogen content is less than 3ml/100g in deposited metal.
There are low levels of residue elements in deposited metal.
The weld metal shows excellent resistance to temper and in-service embritlement.
XUN-225 has excellent welding technology properties. It is suitable for narrow gap welding. Regularly shaped welds are deposited without reduction of area or interface notches. Slag detachability is good.
The flux has low moisture pick-up and granular stability. Flux shall be capable of meeting the applied requirements.

Redrying instruction: The flux has to be redried before use for appr.2h at 300-350℃

Main Constituents（%）

SiO_2+TiO_2	CaO+MgO	Al_2O_3+MnO	CaF_2
15	40	20	25

Mechanical properties of deposited metal

Wire	Yield strength（MPa）	Tensile strength（MPa）	Elongation（%）	Charpy V notch impact strength（J）		Heat treatment
				-20℃	-40℃	
GLES-30CrMo1	≥470	550-700	≥22	≥80	-	650℃×4h
GLES-20CrMo2	≥500	600-750	≥22	-	≥80	690℃×4h

Chemical composition of deposited metal（%）

Wire	C	Si	Mn	P	S	Cr	Mo
GLES-30CrMo1	0.05-0.08	0.15-0.30	0.7-1.0	0.010	0.004	1.0-1.35	0.5
GLES-20CrMo2	0.05-0.08	0.15-0.30	0.5-0.8	0.010	0.004	2.0-2.5	1.0

Applications： Multi-layer welding of 1~1.25Cr-0.5Mo and 2.25%Cr-1Mo heat resisting steels for boiler drums main steam tubes, superheated steam tubes and chemical engineering apparatus.

Welding recommendation: Suitable for single wire welding multi-layer
The flux should be welded on DC +
Preheation and interpasss temperature:200-300℃
Heat input: should be less than 20KJ/cm.

Material to be welded

Boiler and pressure vessels

1Cr-0.5Mo 2.25Cr-1Mo P23 P24