MILL AND LOW-ALLOY STEEL

HIGH STRENGTH STEELS WIRE AND FLUX FOR SAW

XUN-123 Agglomerated Flux for S.A. Welding

Specification: EN760 AWS A5.17/5.23

Classifications SA FB 1 55 AC H5 F11A8-EG-G

Characteristics：XUN-123 is an agglomerated fluoride-basic type flux.

Metallurgical behavior: The behavior of silicon and manganese is neutral, so it should be welded with wires containing relatively high amounts of manganese and silicon.

Grain size: 10 to 60 mesh.

Basicity: 2.8 (BIIW).

As a result of low hydrogen levels (max. 5ml/100g), low oxygen, sulfur, phosphor levels in the weld deposits, uniform mechanical properties with low temperature toughness are obtained. Slag is extremely easy to remove and bead appearance is beautiful in multi-layer narrow gap welding of thick plates.

As the bulk density is low, so is the consumption rate.

Damp flux should be redried at 300-350℃ for 2 hours

Main Constituents（%）

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

Mechanical properties of deposited metal (AWS A5.17/A5.23)

Wire	PWHT	Yield strength（MPa）	Tensile strength（MPa）	Elongation（%）	Charpy V notch impact strength（J）	
					-40℃	-60℃
GLES-40NiCrMo 1	AW	≥690	760-900	≥15	≥90	≥70

Chemical composition of deposited metal（%）

Wire	C	Si	Mn	Mo	Cr	Ni	Others
GLES-40NiCrMo 1	0.05~0.1	0.25~0.35	0.9~1.2	0.4-0.7	0.2-0.7	1.5-3.5	Bal.

Applications：

The flux is most suited to welded joints on high-tensile, fine-grain steels as well as steels which are tough at low temperatures

It is suited to welding with tandem and multi-wire processes.

It is also suited to narrow gap welding with thick plates

The flux can be welded on DC+ and AC.

Material to be welded

General structural steels

790Mpa high strength steels

Boiler steels

Fine-grain structural steels