



XUN-501 Agglomerated Flux for S.A. Welding

Specification :	EN760	AWS A5.17/5.23
Classifications	SA AR 1 88 AC H5	F48A0-EL8

Characteristics: XUN-501 is an agglomerated aluminate-rutile type flux.

Metallurgical behavior: High silicon and manganese pick-up is obtained.

Grain size: 14 to 60 mesh.

Basicity: 0.5 (BIIW).

It has excellent welding technology properties. Regularly shaped welds are deposited without reduction of area or interface notches.

Slag detachability is very good, especially at high speed.

Welding porosity scarcely occur.

Its welding speed is can able to travel up to 120cm/min

The flux has low moisture pick-up and granular stability. Flux shall be capable of meeting the applied requirements. 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	Al ₂ O ₃ +MnO	CaF ₂
30	55	5

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)
					-0℃
GLS-20	AW	≥400	500-600	≥22	≥34

Chemical composition of deposited metal (%)

Wire	C	Si	Mn
GLS-20	0.05~0.1	0.35~0.50	1.2~1.5

Applications:

XUN-501 is suitable for horizontal fillet and butt welding light structural, small pressure vessel, such as small LPG store cylinder.

It is suited to twin-wire, tandem and multi-wire welding at high speeds, the welding speed is more than 120cm/min.

It is particularly useful for welding tube-web-tube joints of finned tubes.

XUN-501 is useful for welding thin plate in single pass and limited pass.

The flux can be welded with DC+ or AC

Material to be welded

General structural steels

Mild steels
490MPa high strength steels

Pressure vessel and boiler steels

H I H II
17Mn4