



MILL AND LOW-ALLOY STEEL
HIGH EFFICIENCY SAW WELDING WIRE AND FLUX

XUN-50T Agglomerated Flux for S.A. Welding

Specification EN760 AWS A5.17/A5.23
Classifications SA MS 1 76 AC H5 F7A0-EG

Characteristics: XUN-50T is an agglomerated Manganese-silicate type flux.
Metallurgical behavior: Low silicon and manganese pick-up is obtained.
Grain size: 10 to 60 meshes.
Basicity: 1.0 (BIIW).
A high current-carrying capacity is a particularly noteworthy feature of this flux. Slag removal is extremely easy and bead appearance is beautiful in high heat input welding.
The diffusible hydrogen content in deposited metal is less than 5ml/100g, so has very good toughness at the low temperature, therefore, crack resistance is extremely high.
Damp flux should be redried at 300-350℃ for 2 hours

Main Constituents (%)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
40	20	30	5

Mechanical properties of deposited metal

Wire	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Charpy V notch impact strength (J)
				-20℃
GLES-50	≥400	500~600	≥22	≥60

Chemical composition of deposited metal (%)

Wire	C	Si	Mn
GLES-50	0.05~0.1	0.3~0.7	1.5~2.2

Applications:

The flux can be used for welding shape of H and box structure, boiler and pressure vessel, pipeline, and shipbuilding.
It is suitable for submerged-arc twin-wire, tandem and multi-wire welding, as well as when using the two-run technique and can also be used to full advantage when welding at slow speeds, such as one side welding, as well as butt and fillet of welding fore one side or two-run

The flux should be welded on DC + or AC

Material to be welded

General structural steels

Mild steels
490MPa high strength steels
590Mpa high strength steels

Ship plates

A B D E A32 A36 D32 D36
Pipe steels
X60 X65 X70 X80

Boiler steels

H I H II
17Mn4 19Mn5 15Mo3

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