



XUN-55E Agglomerated Flux for S.A. Welding

Specification	EN760	AWS A5.17/A5.23
Classifications	SA AZ 1 67 AC H5	F48A0-EH14 F7A0-EG-G

Characteristics: XUN-55E is a special agglomerated flux.

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

Grain size: 10 to 60 meshes.

Basicity: 2.5 (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 flux contain a large amount of iron powder, so it have high deposition rate.

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	Fe
15	30	10	10	30

Mechanical properties of deposited metal

Wire	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Charpy V notch impact strength (J)	
				-0℃	-20℃
GLES-22	≥400	500~620	≥22	≥40	-
GLES-45	≥450	550~650	≥22	-	≥40

Chemical composition of deposited metal (%)

Wire	C	Si	Mn	Mo
GLES-22	0.06~0.15	0.3~0.4	0.95~1.25	0.15-0.3
GLES-45	0.06~0.15	0.2~0.35	1.3~1.7	0.15-0.3



Applications:

The flux can be used for one-side welding with tandem and multi-wire system for mill steel and 490N/mm2 high strength steel for ship and steel frames.

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 and low alloy steel
490MPa high strength steels
590Mpa high strength steels

Ship plates

A B D E A32 A36 D32 D36 EH32 EH36

The flux should be welded on DC + or AC