



MILL AND LOW-ALLOY STEEL
NON ALLOY AND FINE GRAIN STEELS WIRE AND FLUX FOR SAW

XUN-70 Agglomerated Flux for S.A. Welding

Specification : EN760 AWS A5.17/A5.23
Classifications SA AB 1 67 AC H5 F7A4-EG-G

Characteristics: XUN-70 is special agglomerated flux for longitudinal and spiral welded pipelines. It is an agglomerated aluminate-basic type flux.
Metallurgical behavior: The behavior of silicon is neutral and low manganese pick-up is obtained.
Grain size: 10 to 60 meshes.
Basicity: 1.3(BIIW).
Weldability and mechanical properties are excellent also in high speed welding with multi-wire system, slag is extremely easy to remove, and bead appearance is beautiful. It is recommended for single pass, square butt-welding such as longitudinal and spiral seams on pipe. XUN-70produces welds with minimal buildup and good penetration. It is capable of high speed welding with multi-wire. Welds metal shows high impact toughness in high speed welding.
The flux has low moisture pick-up and granular stability. Flux shall be capable of meeting the applied requirements.
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
20	20	35	15

Mechanical properties, typical pipe API X70 seam weld

Wire	Yield strength (Mpa)	Tensile strength (Mpa)	Elongation (%)	Charpy V notch impact strength (J)	
				-20℃	-40℃
GLES-50	605	690	26	155	100

The plate thickness is 14.6mm

Typical chemical composition of metal (%)

Wire	C	Si	Mn	Mo	Ti	B
GLES-50	0.07	0.30	1.60	0.20	0.015	0.002

Applications:

The flux can be used for multi-wire welding at high speed for longitudinal and spiral seam pipe
Suitable for single wire or multi-wire welding with two run technology
The flux should be welded on DC + or AC

Material to be welded

Pipe steels

X42 X52 X56 X60 X65 X70