XUN-80 Agglomerated Flux for S.A. Welding

Specification : EN760 AWS A5.17/A5.23

Classifications SA FB 1 57 AC H5 F8A4-EG-G

Characteristics： XUN-80 is special agglomerated flux for longitudinal and spiral welded pipelines. It is an agglomerated fluoride-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: 2.0(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-80 produces 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_2O_3+MnO	CaF_2
15	35	25	20

Mechanical properties, typical pipe API X80 seam weld

Wire	Yield strength（Mpa）	Tensile strength（Mpa）	Elongation（%）	Charpy V notch impact strength（J）	
				-20℃	-40℃
GLES-58	605	690	26	155	100

The plate thickness is 22mm

Typical chemical composition of metal（%）

Wire	C	Si	Mn	Mo	Ti	B	Cr
GLES-58	0.07	0.30	1.70	0.20	0.015	0.002	0.23

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

X70 X80