XUN-601 Agglomerated Flux for S.A. Welding

Specification : EN760

Classifications SA AF 2 54 AC H5

Characteristics: SJ601 is an agglomerated aluminate-fluoride basic type flux.

Metallurgical behavior: There is minimal chromium loss in the deposited metal. The behavior of silicon and manganese is neutral. With regard to carbon content, the behavior of XUN-601 is also neutral.

Grain size: 10 to 60 mesh.

Basicity: 1.8 (BIIW).

Welded metal shows excellent crack resistance, corrosion resistance and mechanical properties. Toughness of weld metal at -196℃ temperature is satisfied. It has excellent welding technology properties. Regularly shaped welds are deposited without reduction of area or interface notches and surface of welds are smooth appearance and have a fine ripple. Slag detachability is good and without slag residues.

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_2O_3+MnO	CaF_2
10	35	50

Mechanical properties of deposited metal

Wire	Tensile strength（MPa）	Elongation（%）	Sulphuric Acid-Copper Sulphate Corrosion Test	Charpy V notch impact strength（J）		
				20℃	-40℃	-196℃
GLEN-308L	≥510	≥30	Good	≥80	-	≥40
GLEN-309L	≥510	≥25	Good	≥80	-	≥40
GLEN-316L	≥510	≥25	Good	≥80	–	≥40
GLEN-347	≥510	≥30	Good	≥80	–	≥40
GLEN-309LMo	≥550	≥30	Good	≥80	–	–
GLEN-309LNb	≥510	≥30	Good	–	–	–
GLEN-321	≥550	≥30	Good	≥80	–	–
GLEN-2209	≥550	≥20	Good	–	≥80	–

Chemical composition of deposited metal（%）

wire	C	Cr	Ni	Mo	Nb	Ti
GLEN-308L	≤0.04	18.0-21.0	9.0-11.0	-	-	-
GLEN-309L	≤0.04	22.0-25.0	9.0-11.0	-	-	-
GLEN-316L	≤0.08	17.0-20.0	11.0-14.0	2.0-3.0	-	-
GLEN-347	≤0.04	18.0-21.0	9.0-11.0		0.4-1.0	-
GLEN-309LMo	≤0.04	22.0-25.0	12.0-14.0	2.0-3.0	-	-
GLEN-309LNb	≤0.04	22.0-25.0	12.0-14.0	-	0.4-1.0	-
GLEN-321	≤0.08	18.0-21.0	9.0-11.0	-	-	0.7-1.0
GLEN-2209	≤0.04	21.5-23.5	8.5-10.5	2.5-3.5	0.4-1.0	N:0.08-0.20

Applications:

For butt and fillet welding stainless steels when used in conjunction with a range of stainless steel wires. It is suitable for welding low carbon stainless steels.

It can be welded with DC+.

Material to be welded

304, 304L 316 316L, 347, 321, 318