



STAINLESS STEEL AND NICKEL BASE ALLOY  
WELDING WIRE AND FLUX FOR SAW

XUN-602 Agglomerated Flux for S.A. Welding

Specification: EN760

Classifications SA FB 2 AC

Characteristics and Application:

XUN-602 is an agglomerated fluoride-basic type flux for welding stainless steels  
Metallurgical behavior: The behavior of silicon and manganese is neutral. With regard to carbon content, the behavior of XUN-602 is also neutral.  
Grain size: 10 to 60 mesh.  
Basicity: 2.7(BI IW).  
The deposit metal content a low diffusible hydrogen. It is suited to tandem and multi-wire welding. Smooth welds with a good finish are deposited.  
XUN-602 flux is suitable for welding on both DC and AC.  
Damp flux should be redried at 300–350℃ for 2 hours.

Main Constituents (%)

| SiO <sub>2</sub> +TiO <sub>2</sub> | CaO+MgO | Al <sub>2</sub> O <sub>3</sub> +MnO | CaF <sub>2</sub> |
|------------------------------------|---------|-------------------------------------|------------------|
| 15                                 | 35      | 20                                  | 25               |

Mechanical properties of deposited metal

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

Chemical composition of deposited metal (%)

| wire        | C     | Cr        | Ni        | Mo      |
|-------------|-------|-----------|-----------|---------|
| 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-309LMo | ≤0.04 | 22.0-25.0 | 12.0-14.0 | 2.0-3.0 |