



STAINLESS STEEL AND NICKEL BASE ALLOY STRIP AND FLUX FOR SAW

XUN-612 Agglomerated Flux for S.A. Welding

Specification: EN760
Classifications SA CS 2 Cr AC

Characteristics: XUN-612 is an agglomerated calcium-silicate type flux for strip cladding.
Metallurgical behavior: It has chrome compensation
Grain size: 10 to 60 mesh.
Basicity: 1.0(BIIV).
The cladding metal shows excellent wetting and welding properties.
Damp flux should be redried at 300-350°C for 2 hours.

Main Constituents (%)

SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaO+MgO	CaF ₂	S	P
35	15	35	10	≤0.03	≤0.04

Surfacing metal chemical analysis (%)

strip	C	Si	Mn	Cr	Ni	Mo
GLEN-BS308L	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0	-
GLEN-BS309L	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0	-
GLEN-BS316L	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0	2.0-3.0

Applications: For cladding thick mild and low alloyed steel to have high corrosion resistance, typical for corrosion resistant boiler and pressure vessels in the chemical, petrochemical and nuclear industries
It is suitable for strip cladding the first layers in carbon steel with low carbon or ELC steel strip.
It can be welded with DC+.
All dust, oil and rust should be removed before cladding.

Cladding material

308L, 309L 316L