



STAINLESS STEEL AND NICKEL BASE ALLOY STRIP AND FLUX FOR ESW

XUN-618 Agglomerated Flux for ESW

Specification: EN760

Classifications ES A AF 2 DC H5

Characteristics: XUN-618 is an agglomerated aluminate-fluoride-basic type flux for electrosag strip cladding.

Metallurgical behavior: The behavior of chromium is neutral. There is little loss of chromium, so the flux has no chromium compensation.

Grain size: 18 to 60 meshes.

Basicity: 3.8(BIIV).

The electrosag process is stability.

The cladding metal shows excellent wetting and welding properties. Slag detachability is easy.

Damp flux should be redried at 300-350°C for 2 hours.

Main Constituents (%)

SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaF ₂	S	P
5	30	60	≤0.03	≤0.04

Surfacing metal chemical analysis (%)

Strip	C	Si	Mn	Cr	Ni	Nb	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-BS309MoL	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0	-	2.0-3.0
GLEN-BS316L	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0	-	2.0-3.0
GLEN-BS347	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0	8×C%-1.0	-

Applications: It is suitable for strip cladding the first layers in carbon steel with over-alloyed strip and corrosion resistance layers.

Typical application is suitable for electrosag strip cladding corrosion resistant boiler and pressure vessels in the chemical, petrochemical and nuclear industries.

It can be welded with DC+.

All dust; oil and rust should be removed before cladding.

Cladding material

First layers: 309L 309MoL

Corrosion resistance layers: 308L 316L 347