



STAINLESS STEEL AND NICKEL BASE ALLOY STIRP AND FLUX FOR ESW

XUN-6308 Agglomerated Flux for ESW

Specification: EN760

Classifications ES A AF 2 CrNi DC H5

Characteristics: XUN-6308 is an agglomerated aluminate-fluoride-basic type flux for electrosag strip cladding.

Metallurgical behavior: The flux has chromium and nickel 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	≤0.02	≤0.03

Surfacing metal chemical analysis (%)

Strip	C	Si	Mn	Cr	Ni
GLEN-BS308L	≤0.04	≤1.0	≤2.5	18.0-21.0	9.0-11.0

Applications : It is suitable for single-layers electrosag strip surfacing in carbon steel with GLEN-BS308L strip.

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

Single-layers: 308L