



## STAINLESS STEEL AND NICKEL BASE ALLOY STRIP AND FLUX FOR ESW

### XUN-6347 Agglomerated Flux for ESW

**Specification:** EN760

**Classifications** ES A AF 2 CrNiNb DC H5

**Characteristics:** XUN-6347 is an agglomerated aluminate-fluoride-basic type flux for electros slag strip cladding.

Metallurgical behavior: The flux has chromium, nickel and niobium compensation.

Grain size: 18 to 60 meshes.

Basicity: 3.8(BIIW).

The electros slag 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 <sub>2</sub> +TiO <sub>2</sub> | Al <sub>2</sub> O <sub>3</sub> +MnO | CaF <sub>2</sub> | S     | P     |
|------------------------------------|-------------------------------------|------------------|-------|-------|
| 5                                  | 30                                  | 60               | ≤0.02 | ≤0.03 |

#### Surfacing metal chemical analysis (%)

| Strip      | C     | Si   | Mn   | Cr        | Ni       | Mo      |
|------------|-------|------|------|-----------|----------|---------|
| GLEN-BS347 | ≤0.04 | ≤1.0 | ≤2.5 | 18.0-21.0 | 9.0-11.0 | 2.0-3.0 |

**Applications :** It is suitable for single-layers electros slag strip surfacing in carbon steel with XUN-EQ347strip.

Typical application is suitable for electros slag 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: 347