



MILL AND LOW-ALLOY STEEL
LOW TEMPERATURE SERVICE STEEL WIRE AND FLUX FOR SAW

XUN-215 Agglomerated Flux for S.A. Welding

specification:	EN760	AWS A5.17/A5.23
Classification	A FB 1 55 AC H5	F7P10-ENi3-Ni3
		F7P15-EG-Ni3

Characteristics: XUN-215 is an agglomerated fluoride-basic type flux with high basicity.
Metallurgical behavior: The behavior of manganese and silicon is neutral. There is a low S and P pickup
Grain size: 10 - 60 mesh.
Basicity: 2.4 (BIIW).
Diffusion hydrogen content is less than 5ml/100g in deposited metal.
Weld metal shows excellent toughness in low temperature.
XUN-215 has excellent welding technology properties. Regularly shaped welds are deposited without reduction of area or interface notches. Slag detachability is good.
The flux has low moisture pick-up and granular stability. Flux shall be capable of meeting the applied requirements.
Damp flux should be redried at 300-350℃ for 2 hours.

Main Constituents (%)

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
15	20	30	30

Mechanical properties of deposited metal

Wire	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Charpy V notch impact strength (J)	
				-70℃	-101℃
GLS-30Ni3	≥400	500~600	≥22	≥80	≥50
GLS-30Ni35	≥450	550~650	≥22	≥100	≥80

Chemical composition of deposited metal (%)

Wire	C	Si	Mn	Ni
GLS-30Ni3	0.05-0.08	0.2-0.3	0.6-1.0	2.5-3.2
GLS-30Ni35	0.02-0.07	0.2-0.3	0.6-1.0	3.0-3.5

Applications: Multi-layer flat butt and fillet welding of aluminium-killed steels for low temperature service for LPG storage tanks, pressure vessel, installations for low temperatures service and structures to be used in frigid areas.
The flux should welded on DC + or AC
Satisfactory impact properties are obtained with heat input of less than20kl/cm.