



HARDFACING **WELDING WIRE AND FLUX FOR ESW**

XUN-412 Agglomerated Flux for S.A. Welding

Specification: EN760
Classification SA CS 2 55 AC H5
Characteristics and Application:

XUN-412 is an agglomerated calcium-silicate type flux.

Grain size: 10 to 60 mesh.

Metallurgical behavior: high silicon pick-up and the behavior of manganese is neutral.

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Basicity: 1.2 (BIIW).

There are low levels of residue elements in deposited metal.

The weld metal shows excellent resistance to crack.

XUN-412 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.

For surfacing of roller for continuous casting, steel rolling, transport, etc. of a series of 13%Cr stainless steels and middle or low alloy steels.

The flux can combine with 13%Cr series of cored wires and sold wire.

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

Main Constituents (%)

SiO₂+TiO₂	CaO+MgO	Al₂O₃+MnO	CaF₂
30	20	20	30