



HARDFACING **WELDING WIRE AND FLUX FOR ESW**

XUN-416 Agglomerated Flux for S.A. Welding

Specification: EN760
Classification SA FB 2 55 AC H5

Characteristics and Application:

XUN-416 is an agglomerated fluoride-basic type flux with high basicity .

Grain size: 10 to 60 mesh.

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

Grain size: 10 - 60 mesh.

Basicity: 2.7 (BIIW).

There are low levels of residue elements in deposited metal. Weld metal is very purity.

The weld metal shows excellent resistance to crack.

XUN-416 has excellent welding technology properties. Slag removal is easy at high temperature. Smooth defect free weld bead appearance.

For surfacing of roller for continuous casting, steel rolling, transport, etc.

The flux is suited for combining with high alloy wire (sold wire or core wire) for surfacing, such as 414,414N, 410NiMoV,etc.

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
15	40	20	25