



HARDFACING **WELDING WIRE AND FLUX FOR ESW**

XUN-418 Agglomerated flux for S.A. Cladding

Specification: EN760

Classification SA CS 2 55 AC

Characteristics and Application:

XUN-418 is an agglomerated calcium-silicate type flux .

Grain size: 10 to 60 mesh.

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

Grain size: 10 - 60 mesh.

Basicity: 0.9 (BIIW).

There are low levels of residue elements in deposited metal.

The flux is used in strip cladding with a series of 13%Cr consumables

XUN-418 has excellent wetting and welding technology properties. Smooth defect free weld bead appearance. Slag detachability is good.

The flux has low moisture pick-up and granular stability. Flux shall be capable of meeting the applied requirements.

For strip cladding 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 strips and sold wire, cored wire.

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

Main Constituents (%)

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