



HARDFACING **WELDING WIRE AND FLUX FOR ESW**

XUN-428 Agglomerated flux for ESW Cladding

Specification: EN760

Classification SA CS 2 55 AC

Characteristics and Application:

XUN-428 is an agglomerated aluminate-fluoride type flux .

Grain size: 10 to 60 mesh.

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

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Basicity: 4.0 (BIIW).

There are low levels of residue elements in deposited metal.

The flux is used in strip cladding with GLENN BS 430 to get the composition of the 410NiMo.

XUN-428 has excellent wetting and welding technology properties. Smooth defect free weld bead appearance. Slag detachability is good.

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 (%)

$\text{SiO}_2 + \text{TiO}_2$	$\text{CaO} + \text{MgO}$	$\text{Al}_2\text{O}_3 + \text{MnO}$	CaF_2
30	20	20	30

Applications:

Welding recommendation: Suitable for cladding thick mill and low alloyed steels with 30-50-60 wide strips

The flux should be welded on DC + .

Preheating and interpass temperature: 150-250°C

All dust, oil and rust should be removed.