



XUN-428A Agglomerated flux for ESW Cladding

Specification: EN760
Classification SA CS 2 55 AC

Characteristics: 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. The nickel and molybdenum pick-up

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Basicity: 4.0 (BIW).

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.

Damp flux shoule be redried at 300-350℃ for 2 hours.

Main Constituents (%)

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