



STAINLESS STEEL AND NICKEL BASE ALLOY STRIP AND FLUX FOR ESW

XUN-628 Agglomerated Flux for ES Welding

Specification: EN760

Classification: ES A AF 2 DC

Characteristics: XUN-628 is an agglomerated aluminate-fluoride-basic type flux for electrosag strip cladding.

Metallurgical behavior: The flux provides minimizing burn-off of alloying elements.
Minimum silicon transfers from the flux to the welding metal.

Grain size: 10 - 60 mesh.

Basicity: 4.0 (BIW).

The cladding metal chemical composition is nearly matching strip in the second layer.

Cladding weld is the smooth, tight ripples and excellent wetting; thereby it may be used in the as-welded condition.

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

Main Constituents (%)

SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaF ₂
5	30	60

Chemical composition of deposited metal (%)

wire	C	Mn	Si	Cr	Ni	Mo
GLNICKEL-BS82	≤0.03	2.5-3.5	≤0.5	18.0-22.0	bal	Nb+Ta 2-3
GLNICKEL-BS625	≤0.03	≤0.5	≤0.5	20.0-23.0	bal	8.0-10.0

Applications: For cladding with nickel-base alloy strip on the carbon steel and low alloy steel.

Welding recommendation: The flux should be welded on DCEP
All dust, oil and rust should be removed.