

Classifications

EN ISO 14174

S A FB 1 55 AC H5

Characteristics and typical fields of application

UV 418 TT is an agglomerated fluoride basic flux for submerged arc welding of a very wide scope of unalloyed and low alloyed steel grades. It has a high basicity and neutral metallurgical behavior and is designed for medium and high strength, fine-grained structural steels.

Delivers very good toughness properties at -75°F and CTOD values at -20°F in as welded and PWHT-condition.

Due to its high current carrying capacity, this flux is well suited for 2 run procedures with unalloyed and low alloyed wire grades (e.g. Union S 2 Mo and Union S 3 MoTiB), with very good toughness properties. In general, the flux has excellent bead appearance with very good slag release, even in narrow gap joint preparations.

Flux properties

Polarity	DC / AC
Basicity index (Boniszewski)	2.6 wt-%
Grain size (EN ISO 14174)	3 – 20 (0.3 – 2.0 mm)
Flux consumption	1.0 lb flux per lb wire
Redrying	620°F +/- 45 for 2 hrs min.
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100gr (as produced / re-dried)

Composition of sub-arc welding flux

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂	CaF ₂ +CaO+MgO
wt. %	15	38	20	25	-