

## **COROFLUX<sup>®</sup> 200**

### **CLASSIFICATION:**

DIN EN 760 : SA FB 1 65 DC  
BFB 4 543 DC 12 M 2-16

### **GENERAL CHARACTERISTICS:**

COROFLUX 200 is a highly basic agglomerated flux for hardfacing. This welding flux is recommended for the welding of mill rolls and continuous casting rolls in conjunction with martensitic CORODUR flux cored wires. However it can be used for other CORODUR submerged-arc wires with the approval of our technicians. The slag that is formed, is very easily removable and the thickness of the weld bead can be up to 5mm. This flux can also be used for dual-wire feeding and for strip welding.

### **APPLICATION:**

Non-alloying powder, especially for welding of rolls.

### **WELDING RECOMMENDATIONS:**

Power source:	Constant Voltage with + Terminal
Consumption:	0.8-1.5 fused flux kg/kg wire, depending on welding energy in the torch.
Apparent density:	1.2 Kg/dm <sup>3</sup>
Granulometry:	0.2-1.6 mm (Tyler 10x65 mesh)
Basicity index:	2,8 (according to Boniszewski)
Redrying:	2 hours at 300-350°C

### **PARAMETER:**

Single wire welding:	350-600A with 26-32V
Dual wire welding:	700-1200A with 27-33V
Strip welding:	450-1100A with 26-32V

### **FORMS OF DELIVERY:**

25 Kg Bag