

COROFLUX[®] HL

CLASSIFICATION:

DIN EN 760 : SA CS 2 Cr 64 DC

GENERAL CHARACTERISTICS:

COROFLUX HL is an agglomerated flux for submerged arc 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. The flux is nearly burn-off neutral for C and Mn, and slightly alloying in Si and Cr. This flux can also be used for dual-wire feeding and for strip welding.

WELDING RECOMMENDATIONS:

Consumption: 0.8-1.5 fused flux kg/kg wire, depending on welding energy in the torch.
 Apparent density: 1.1 Kg/dm³
 Granulometry: 0.3-1.6 mm
 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

MAIN COMPOSITION:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
32%	33%	22%	11%

FORMS OF DELIVERY:

25 Kg Bag