



FLUX UP LA01

Agglomerated Rutile Welding Flux

Classification

ISO 14174 S A AR 1 76 AC H5

Description & Applications

Aluminate-Rutile Flux for submerged arc welding (SAW-process) for joint welding of low-alloy structural and boiler quality steels with yield strengths (Y_s) up to 355MPa. The flux shows constant metallurgical characteristics.

Flux UP LA01 is formulated to achieve high speed welding (up to 2/ m/min), good weld bead appearance and easy slag removal (even in fillet welding).

Recommended to use for single-run, two-run and fillet welding.

Wires recommended for

<i>ISO 14171-A</i>	<i>AWS A5.17</i>
S1	EL12
S2	EM12
S2Si	EM12K
S2Mo	EA2
<i>ISO 24958-A</i>	<i>AWS A5.23</i>
S S CrMo1	EB2

Typical Chemical Composition (%)

SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaO + MgO	CaF ₂	Basicity according To Boniszewski
25	55	5	10	~0.6

Flux Properties

Density (kg / dm ³)	Grain size ISO 14174	Current carrying capacity
1.0	2 - 16 ; Tyler 10x65	Up to 800A (AC or DC) using one wire

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All Weld Metal Typical Chemical analysis (%)

Wire	C	Si	Mn	Cr	Mo
S1	0.04-0.08	0.3-0.6	0.8-1.1		
S2	0.04-0.08	0.3-0.6	1.0-1.4		
S2Si	0.04-0.08	0.4-0.8	1.0-1.4		
S2Mo	0.04-0.08	0.3-0.7	1.0-1.4		0.4-0.6
S S CrMo1	0.04-0.08	0.3-0.7	0.9-1.3	1.0	0.4-0.6

All Weld Metal Typical Mechanical Properties

Wire	R _{p0,2} (MPa)	R _m (MPa)	A (%)	+20°C	KV (J) 0°C	-20°C
S1	>400	>510	>24	>70	>40	
S2	>420	>530	>22	>70	>47	
S2Si	>430	>540	>22	>70	>47	>27
S2Mo	>480	>580	>20	>60	>47	>27
S S CrMo1 *	>470	>570	>20	>50		

* After PWHT at 680°C/10h

Storage Recycling and Drying

It is recommended to store and use the flux up to 1 year after delivery in dry storage rooms. Nevertheless, the flux can be used even if stored for more than one year, just requires the user to make a weldability test to check if all is well.

Drying conditions specific to the flux: 200 ± 50°C. Supplied in moisture proof packaging.