



WELDING

FLUX UP Ni02

*Agglomerated Welding Flux
For Nickel alloys*

Classification

ISO 14174 S A AF 2

Description & Applications

Basic agglomerated welding flux for submerged arc welding (SAW) and surfacing in combination with Nickel alloys wire electrodes. Easy slag removal, nice aspect of weld bead. Could be used for dissimilar assembly between Nickel alloys and stainless steels.
The metallurgical behaviour of the flux is low Silicon pick up.

Wires recommended for:

AWS A5.14	ISO 18274
ERNiCr-3	S Ni6082
ERNiCrMo-3	S Ni6625
ERNiCrMo-13	S Ni6059

Typical Chemical Composition (%)

SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaF ₂	Basicity according To Boniszewski
14 %	30 %	52 %	~2.4

All Weld Metal Mechanical Properties

Density (kg / dm ³)	Grain size ISO 14174	Current capacity
1.2	0.2 – 1.25 mm	DC+, 900A using 60 x 0.5mm strip electrode

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All Weld Metal Chemical analysis (%)

Wire	C	Si	Mn	Cr	Ni	Mo	Nb	Fe
ERNiCr-3	0.015	0.30	3.0	19.8	76.0	0.50	2.3	1.0
ERNiCrMo-3	0.025	0.20	0.30	21.5	65.0	9.0	3.2	1.0
ERNiCrMo-13	≤0.010	0.02	0.10	23.0	>56.0	15.0	Al: 0.10	0.20

All Weld Metal Mechanical properties

Wire	$R_{p0,2}$ (MPa)	R_m (MPa)	A (%)	KV (J)
ERNiCr-3	420	650	45	+20°C 200 -196°C 80
ERNiCrMo-3	470	700	40	+20°C 140 -196°C 70
ERNiCrMo-13	470	750	45	+20°C 170 -196°C 130

Storage Recycling and Drying

The flux can be stored up to 3 years after delivery dry storage rooms. Flux that has picked up moisture should be re-dried 2h at 300-350°C. Flux could be re-drying up to 3 times.