

SWX 282

EN ISO 14174: S A AF 2 DC

Benefits:

- helps produce welds with excellent CVN toughness even at temperatures as low as -196°C
- beneficial for multi-pass welding due to excellent slag removal which minimizes clean-up time and risk of inclusion
- supplied in moisture-proof packaging that eliminates the need to re-dry unopened product

Typical Applications:

- joining nickel-based alloys, such as Alloy 82, Alloy 600, and Alloy 625
- chemical & petrochemical refining
- pulp & paper processing
- offshore

Flux Type:

Agglomerated aluminate-fluoride flux

Basicity Index (Boniszewski): 1.9

Alloy Transfer: None

Density: ~1.2 kg/L

Grain Size: 0.2 – 2.0 mm/ 10 – 70 mesh

Type of Current: DCEP

Typical Composition:

Al₂O₃ + MnO ~30%
CaO + MgO..... ~25%
SiO₂ + TiO₂..... ~20%
CaF₂..... ~20%

Packaging Available

- 55 lb. (25 kg.) EAE Bag

Commonly Used With:

- SDX NiCr-3
- SDX NiCrMo-3

SWX 382

EN ISO 14174: S A AAS 2B DC

Benefits:

- offers good bead appearance, welding characteristics, and slag removal for productive cladding with minimal part post-work
- supplied in moisture-proof packaging that eliminates the need to re-dry unopened product

Typical Applications:

- joining nickel-based alloys, such as Alloy 82, Alloy 600, and Alloy 625
- chemical & petrochemical refining
- pulp & paper processing
- offshore

Flux Type:

Agglomerated acid-aluminum-silicate flux

Basicity Index (Boniszewski): 3.7

Alloy Transfer: None

Density: ~1.1 kg/L

Grain Size: 0.2 – 2.0 mm/ 10 – 70 mesh

Type of Current: DCEP

Typical Composition:

Al₂O₃ + MnO ~30%
CaO + MgO..... ~25%
SiO₂ + TiO₂..... ~20%
CaF₂..... ~20%

Packaging Available

- 55 lb. (25 kg.) EAE Bag

Commonly Used With:

- SDX NiCr-3
- SDX NiCrMo-3

SDX NiCr-3

AWS A5.14: ErNiCr-3

EN ISO 18274: S Ni6082

Benefits:

- produces a nominal 20% Cr/3% Mn/3% Nb nickel-based alloy deposit when used with recommended fluxes
- provides excellent resistance to corrosion resistance and high service temperatures

Typical Applications:

- joining nickel alloys such as Alloy 600 and Alloy 82
- joining 9% Nickel alloys for cryogenic service
- joining chromium-molybdenum steel/stainless steel dissimilar combinations

Recommended Fluxes:

SWX 282

SDX NiCrMo-3

AWS A5.14: ERNiCrMo-3

EN ISO 18274: S Ni6625

Benefits:

- produces a nominal 22% Cr/9% Mo/3.5% Nb nickel-based alloy deposit when used with recommended fluxes
- provides excellent resistance to general and pitting corrosion, and high service temperatures

Typical Applications:

- joining nickel alloys such as Alloy 625
- joining 9% Nickel alloys for cryogenic service
- joining high-molybdenum stainless steels
- joining chromium-molybdenum steel/stainless steel dissimilar combinations

Recommended Fluxes:

SWX 282

Cromastrip NiCr-3

A5.14: EQNiCr-3

EN ISO 18274: Ni6082

Benefits:

- produces a nominal 20% Cr/3% Mn/3% Nb nickel-based alloy deposit when used with recommended fluxes
- provides excellent resistance to corrosion resistance and high service temperatures

Typical Applications:

- cladding carbon, and low-alloy steels using the submerged arc process

Recommended Fluxes:

SWX 305

Standard Widths:

30 mm (1.18"), 60 mm (2.36"),
90 mm (3.54")

Cromastrip NiCrMo-3

A5.14: EQNiCrMo-3

EN ISO 18274: Ni6625

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- provides excellent resistance to general and pitting corrosion, and high service temperatures

Typical Applications:

- cladding carbon, and low-alloy steels using the submerged arc process

Recommended Fluxes:

SWX 305

Standard Widths:

30 mm (1.18"), 60 mm (2.36"),
90 mm (3.54")

