

SubCOR™ SL P9

Benefits:

- maintains creep and scale resistance at temperatures up to 600°C (1110°F) for predictable component lifespan in elevated-temperature service
- nominal 9% chromium/1% molybdenum weld deposit composition is suitable for welding creep-resistant steels of similar composition
- unique seamless composite wire manufacturing process provides unmatched product consistency for excellent uniformity of weld metal properties

Typical Applications:

- boilers & pressure vessels
- power generation components
- chemical/petrochemical refineries
- process piping

Recommended Fluxes:

SWX 150

Standard Diameters:

3/32" (2.4 mm), 1/8" (3.2 mm),
5/32" (4.0 mm)

SubCOR™ SL P91

Benefits:

- maintains creep and scale resistance at temperatures up to 600°C (1110°F) for predictable component lifespan in elevated-temperature service
- nominal 9% Cr/1% Mo/V weld deposit composition is suitable for welding creep-resistant steels of similar composition
- unique seamless composite wire manufacturing process provides unmatched product consistency for excellent uniformity of weld metal properties

Typical Applications:

- boilers & pressure vessels
- power generation components
- chemical/petrochemical refineries
- process piping

Recommended Fluxes:

SWX 150

Standard Diameters:

3/32" (2.4 mm), 5/32" (4.0 mm)

SubCOR™ SL P92

Benefits:

- maintains creep and scale resistance at temperatures up to 650°C (1200°F) for predictable component lifespan in elevated-temperature service
- nominal 9% Cr/1% Mo/W/V weld deposit composition is suitable for welding creep-resistant steels of similar composition
- unique seamless composite wire manufacturing process provides unmatched product consistency for excellent uniformity of weld metal properties

Typical Applications:

- boilers & pressure vessels
- power generation components
- chemical/petrochemical refineries
- process piping

Recommended Fluxes:

SWX 150

Standard Diameters:

3/32" (2.4 mm), 1/8" (3.2 mm),
5/32" (4.0 mm)

SubCOR™ SL 735 1W-5W

Benefits:

- specially formulated to maintain good mechanical properties when performing high dilution welds single or two-run welds using one or multiple wires
 - SubCOR SL 1W is intended for single-wire welding
 - SubCOR SL 2W, 3W, 4W, and 5W are intended for two, three, four, and five-wire welding, respectively. Use in conjunction with Hobart solid wires; only one SubCOR SL 735 wire is needed
- unique seamless composite wire manufacturing process provides unmatched product consistency for excellent uniformity of weld metal properties

Typical Applications:

- pipe mills
- pipe double jointing
- pressure vessels
- heavy equipment

Recommended Fluxes:

SWX 150

Standard Diameters:

3/32" (2.4 mm), 5/32" (4.0 mm)

SWX 220

EN ISO 14174: S A AF 2 DC

Benefits:

- versatile product; suitable for use with a wide range of Hobart stainless wires and stainless applications
- provides good weld appearance and wetting action into the side
- 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 austenitic & duplex stainless steels in similar and dissimilar combinations
- offshore & nuclear fabrication
- petrochemical industry
- chemical storage & processing
- paper & pulp processing
- food & medical equipment

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 Diffusible Hydrogen:

<5 mL/100g

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 308L
- SDX 347
- SDX 216L
- SDX 309L
- SDX 309LMo
- SDX 2209
- SDX 2594

SWX 305**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 (EAE BAG) that eliminates the need to re-dry unopened product

Typical Applications:

- **SAW cladding carbon**, low-alloy, and stainless steels with a stainless overlay
- chemical & petrochemical processing
- pulp & paper processing
- pressure vessels
- offshore & nuclear fabrication

Flux Type:

Agglomerated acid-aluminum-silicate flux

Basicity Index (Boniszewski): 1.1**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 ~20%
 CaO + MgO..... ~5%
 SiO₂ + TiO₂..... ~10%
 CaF₂..... ~60%

Packaging Available

- 55 lb. (25 kg.) EAE Bag

Commonly Used With:

- Cromastrip 308L
- Cromastrip 316L
- Cromastrip 347

SWX 330**EN ISO 14174: ES A FB 2B DC****Benefits:**

- provides high current carrying capacity for high deposition parameters at standard speeds
- offers excellent slag removal, even on preheated surfaces
- supplied in moisture-proof packaging (EAE BAG) that eliminates the need to re-dry unopened product

Typical Applications:

- **electroslag (ESW) cladding** carbon, low-alloy, and stainless steels with a stainless overlay
- chemical & petrochemical processing
- pulp & paper processing
- pressure vessels
- offshore & nuclear fabrication

Flux Type:

Agglomerated fluoride-basic flux

Basicity Index (Boniszewski): 3.8**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 ~25%
 SiO₂ + TiO₂..... ~10%
 CaF₂..... ~65%

Packaging Available

- 55 lb. (25 kg.) EAE Bag

Commonly Used With:

- Cromastrip 21.11 L
- Cromastrip 21.13.3 L
- Cromastrip 21.11 LNb

SWX 340**EN ISO 14174: ES A FB 2B DC****Benefits:**

- designed to allow high ESW travel speeds of up to 17.7 ipm (45 cm/min)
- offers a high current-carrying capacity
- provides excellent slag removal, bead contour, and bead appearance
- supplied in moisture-proof packaging that eliminates the need to re-dry unopened product

Typical Applications:

- high-speed cladding of stainless steels using the electro-slag (ESW) process
- pressure vessels
- petrochemical industry

Flux Type:

Agglomerated fluoride-basic flux

Basicity Index (Boniszewski): 4.1**Alloy Transfer:** None**Density:** ~1.1 kg/L**Grain Size:** 0.2 – 1.2 mm/ 16 – 70 mesh**Type of Current:** DCEP**Typical Diffusible Hydrogen:** <5 mL/100g**Primary Flux Composition:**

Al₂O₃ + MnO ~20%
 CaO + MgO..... ~5%
 SiO₂ + TiO₂..... ~5%
 CaF₂..... ~70%

Packaging Available:

55 lb. (25 kg) EAE Bag

Commonly Used With:

- Cromastrip 308L
- Cromastrip 309L
- Cromastrip 309LNb
- Cromastrip 309LMo
- Cromastrip 316L
- Cromastrip 347