UN–SJ301 AGGLOMERATED FLUXES FOR SUBMERGED ARC WELDING 埋弧用烧结焊剂

Standard: AWS/ASME SFA–5.17 F6A0–EL8 F6A2–EM12 GB/T5293 F4A2–H08A

Description: accompanying suitable wires(H08A, H08E, H08MnA, etc.), Mainly applied in the welding of normal low carbon steel and some low alloy steel(like Q235, 20g, X65, etc.) structure and the submerged welding of boiler pressure vessels, ships, pipe lines, etc. Its deposit metal owns perfect toughness. It suits the submerged welding with multiple layers, double sides single layer, and multiple wires.

Chemical Composition Wire(%)

SiO_2+TiO_2	CaO+MgO	Al_2O_3+MnO	CaF2	S	P
25–35	15–25	30–40	5–15	≤0.06	≤0.08

Mechanical Properties of Deposit Metal(based on GB/T5293 to combine JH–SJ501)

Test iem	Yield strength (δ s) Mpa	Tensile strength (δ b) Mpa	Elongation (δ 5) %	Charpy–V Impact Test(J) ℃		
				+20	0	–20
H08A	≥330	415–550	≥22	≥70	≥50	≥27
H08MnA	≥400	480–650	≥22	≥70	≥50	≥27
H08MnMoA	≥550	620–750	≥18	≥60	≥50	≥27

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Product Name	Applicable Standards	Flux Type	Major Applications
UN–SJ101	F4A4–H08MnA F5A4–H10Mn2	Soda–fluorine type	Accompanying suitable wires(H08MnA、H10Mn2、H08MnMoA) to weld low carbon steel and low alloy steel, like shipbuilding, machinofacture, pressue vessels, etc.
UN–SJ101G	F4A4–H08MnA F5A4–H10Mn2	Soda–fluorine type	With applicable wires(H10Mn2,H08MnA,H08MnMoA,H08C,JH–WQ1, JH–WQ3,JH–WQ4,JH–WGX2)to weld(Q345,14MnNbq, WQ490D, WQ490E,WH530,X70,X80,A710,etc.)low alloy steel structure and propeller and straight pipe joints. Resulting in good low temperature impact toughess and good welding technological characteristics
UN–SJ402	F5A0–H08A	Calcium–silicon type	With applicable wires(H08MnA,H10Mn2,H08MnMoA)to weld low carbon steel and low alloy steel, like shipbuilding, machinofacture, pressure vessels, etc.
UN–SJ105		Soda–fluorine type	Accompanying suitable wires to conduct overlaying welding on surface of rollers
UN–SJ102	F4A4–H08MnA F5A4–H10Mn2	Soda–fluorine type	With applicable wires(JH–WQ1,JH–WQ3,JH–WQ4,JH–WGX2)to weld(Q345,14MnNbq, WQ490D,WQ490E,WH530,etc)low alloy steel structure and propeller and bridges constructed with low alloy steel. Resulting in good low temperature impact toughness and good welding technological characteristics.
UN–SJ403	F4A4–H08MnA F4A2–H08A	Calcium–silicon type	Roller agglomerated fluxes for overlaying welding with applicable wires to weld low cardon steel and certain low alloy steel
UN–SJ501 **UN**–SJ501M	F4A0–H08A	aluminum–tianium type	Accompanying suitable wires(H08A,H08MnA)to weld low carbon steel, boiler steel, steel pipe materials, etc. Can be applied in multiple layer and wires welding. JH–SJ510M is a fine grain flux, its speed may come up to 70m/h when welding water wall of power plant boiler
UN–SJ503	F5A3–H08MnA	aluminum–tianium type	With applicable wires(H08A,H08MnA)to weld normal low carbon steels of medium thickness, can be applied in multiple layer and wires welding.
UN–SJ601	F308–H0Cr21Ni10 F316–HCr19Ni2Mo2 F309–HCr24Ni13	basic	Accompanying suitable wires(H0Cr21Ni10, H00Cr21Ni10,H00Cr19Ni12Mo2,etc.)to weld major structures of stainless steel and high alloy heat resistance steel, etc.