

**McKay MK-SS Submerged Arc Flux**

McKay MK-SS flux is an agglomerated flux containing Chromium for the welding of AISI 300 and 400 series stainless steels. The addition of Chromium helps to reduce the losses caused by oxidation in the arc. The weld has good mechanical properties and impacts and the weld bead appearance is clean

and well shaped. McKay MK-SS can also be used to join dissimilar steels such as 300 series stainless to low carbon steel using an ER309L type wire. When welding stainless steels it is recommended to keep the heat input to below 25 Kjoules/cm to avoid cracks during the solidification stage.

**SPECIFICATION**

AWS A5.17/ASME SFA 5.17

ER-308, ER-308L, ER-309, ER-309L, ER-316, ER-316L  
ER-410, ER-420, ER-410NiMo, ER-430, ER-347

**FLUX CHARACTERISTICS**

|                         |          |
|-------------------------|----------|
| Maximum Welding Current | 800Amp   |
| Polarity                | DC or AC |

**PACKAGING DATA**

McKay MK-SS Submerged Arc Flux is supplied in 25Kg Bags  
item N° 071404

**STORAGE AND RE-BAKING**

The higher the basicity index of agglomerated fluxes, the more hygroscopic such a flux would be. All agglomerated fluxes should therefore be stored in conditions of less than 70% relative humidity. Welding with damp flux can cause porosity. Redrying of flux suspected of being moist should be done for approximately two hours at about 300°C at a flux depth of about 25mm.

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