

PRODUCT DATA SHEET

McKay MK-N Submerged Arc Flux

McKay MK-N is totally neutral agglomerated flux, designed for welding with solid and tubular wires of the 400 series stainless steels. It can also be used with low alloy steel wires. It features clean slag removal with wires containing Nb and V, excellent recovery of the alloying elements from the tubular wires, such as Cr, Ni, Mo, Nb and V and accepts welding with twin-arc and oscillating technique, with currents up to 1 000 A. McKay MK-N flux should be used with wires containing at least 0,20% Si, in order to avoid porosity.

Applications

The main application of McKay MK-N flux is the rebuilding of steel mill roll with tubular and solid wires of the 400 series stainless steels. It can also be used to rebuild shafts, wheels and journals.

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. Re-drying of flux suspected of being moist should be done for approximately two hours at about 300°C at a flux depth of about 25 mm.

Typical Weld Metal Data

Product	Composition of Weld Metal Deposited											Hardness HRc
	% C	% Mn	% Si	% S	% P	% Mo	% Cr	% Ni	% Nb	% W	% V	
McKay TA887-S	0,12	1,0	0,6	0,01	0,015	1,5	12,5	2,5	0,15	-	0,2	40
McKay TA8620-S	0,12	0,8	0,4	0,01	0,015	0,2	0,5	0,4	-	-	-	21
McKay TA861-S	0,15	0,9	0,5	0,01	0,015	0,6	1,7	-	-	-	-	32
McKay TA 242-S	0,14	2,0	0,8	0,01	0,015	0,7	3,0	-	-	-	-	40
McKay TA258-S	0,34	1,2	0,5	0,01	0,015	1,5	6,0	-	-	1,4	-	54
McKay TA410-S	0,08	1,0	0,6	0,01	0,015	-	12,8	-	-	-	-	36
McKay TA A250-S	0,19	1,0	0,5	0,01	0,015	-	12,3	-	-	-	-	50
McKay TA 865-SMod	0,18	1,1	0,4	0,01	0,015	1,0	13,5	2,3	0,15	-	0,15	48
WASA 414MM-S	0,15	0,9	0,5	0,013	0,022	1,2	12,5	2,0	0,17		0,18	42 - 45
Lincore ER423L	0,15	1,2	0,4	0,01	0,02	1,0	11,5	2,0	-		0,15	42 - 45
Stoody Thermoalad 423L	0,15	1,2	0,5	0,012	0,022	1,0	11,7	2,0	-		0,15	43 - 45
EB3	0,1	0,96	0,16	0,01	0,019	1,08	2,15	-	-		-	-
EM-12K	0,1	0,88	0,19	0,019	0,02	-	-	-	-		-	-

Packing Data

Pack mass (bags/kg)	Item Number
25,0	W071406

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