

Metrode NiCr Flux

Metrode NiCr Flux is an agglomerated, fluoride basic flux of high basicity. The high basicity ensures low losses of critical alloying elements in the transfer to the weld deposit. The low silica content ensures a low silicon content of the weld metal and reduces the risk of hot cracking.

Applications

Metrode NiCr Flux is used for welding nickel-based alloys for a wide range of applications where either corrosion resistance, high temperatures or cryogenic properties are required. Alloys of the Inconel® and Hastalloy® type are most commonly used. In particular, it can be used in conjunction with the following wires: ERNiCr-3, ERNiCrMo-3 and ERNiCrMo-4.

Basicity

Boniszewski 3.0

Flux Operating Characteristics

Metrode NiCr Flux can be used DC+, DC- and AC although DC+ is preferred. It is normally intended for single wire operation with wire size up to 3,2 mm diameter and current up to about 450 A, although smaller diameter wires and lower currents are sometimes used with Ni-based alloys to minimise the risk of hot cracking.

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 a damp flux can cause porosity. Re-drying of flux suspected of being moist should be done for approximately 1-3 hours at about 250-400°C at a flux depth of about 25 mm.

Classifications

EN	760	SA FB2
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Packing Data

Pack Mass (kg)	Item Number
20	W077702

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