



METRODE SSB FLUX

Metrode SSB flux is a basic non-alloying agglomerated flux for submerged arc welding with a wide range of stainless steels.

CLASSIFICATIONS

BS EN	760 SA	AF2 DC
DIN 32522	B FB6	63353 DC8M

CHEMICAL ANALYSIS (TYPICAL)

40%(Al₂O₃+MnO) + 10%(SiO₂+TiO₂) + 50%(CaF₂)

Wire	%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Mo	%Cu	%N	Other
308Lsi	0.02	1.2	0.6	0.01	0.02	19.7	10	-	0.1	-	-
347Si	0.03	1.2	0.6	0.01	0.02	19.2	10	-	0.1	-	0.5Nb
316Lsi	0.02	1.2	0.6	0.01	0.02	18.2	12	2.6	0.1	-	-
309Lsi	0.03	1.2	0.6	0.01	0.02	24	12.5	-	0.1	-	-
Zeron 100X	0.02	0.6	0.4	0.01	0.02	24.5	9.3	3.6	0.7	0.23	0.7W

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED
CONDITION)**

Wire	Tensile Strength	0.2% Proof Stress	Elongation 4d	Charpy V-Notch
308Lsi	570MPa	450MPa	41%	40J@-196°C
347Si	630MPa	470MPa	35%	30J@-100°C
316Lsi	570MPa	450MPa	41%	>45J@-130°C
309Lsi	600MPa	475MPa	35%	70J@-50°C
Zeron 100X	920MPa	725MPa	25%	40J@-50°C

PACKING DATA

Metrode SSB Flux is supplied in sealed moisture resistant 20Kg metal drums.
Metrode SSB should be redried at 250-400°C for 1-3hrs.

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