

## SIF 501

Submerged Arc Welding Flux - Paslanmaz Çeliklerin Kaynağı ve Sert Dolgu Uygulamaları

### Standards

EN ISO 14174	S A FB 2 DC
TS EN ISO 14174	S A FB 2 DC

### Properties and Applications

Fluorite-basic type, agglomerated submerged arc welding flux, which is designed for butt and fillet welding stainless steel and corrosion resistance steels. It is also suitable to use in surfacing of stainless steels and unalloyed steels with stainless steel welding wire. Especially used for welding stainless steel storage tanks in chemical tankers, cryogenic tanks and pressure vessels. Provides good welding characteristics and easy slag removal even on medium and thick section welding. Weld bead is very smooth and pore free. Slag is generally self releasing.

### Typical Chemical Values of Weld Metal

Welding Wire	Type of Analysis	C	Si	Mn	Cr	Ni	Mo	Nb	N
SI 308L	Weld Deposit	0.02	0.35	1.60	18.00	9.00			
SI 309L	Weld Deposit	0.02	0.40	1.75	20.00	11.00			
SI 316L	Weld Deposit	0.02	0.35	1.65	18.00	10.00	2.50		
SI 347	Weld Deposit	0.04	0.35	1.50	19.00	8.50		0.30	
SI 2209	Weld Deposit	0.02	0.45	1.70	22.00	8.00	2.50		0.10
SI 307	Weld Deposit	0.04	0.85	5.50	18.50	7.00			

### Typical Mechanical Values of Weld Metal

Test Condition	Welding Wire	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SI 308L	380	530	38	20°C → 90	-60°C → 70	-196°C → 50
As welded	SI 309L	410	560	35	20°C → 80	-60°C → 60	-196°C → 40
As welded	SI 316L	420	570	38	20°C → 75	-60°C → 55	-196°C → 45
As welded	SI 347	460	610	32	20°C → 90	-60°C → 75	-196°C → 45
As welded	SI 2209	600	770	31	20°C → 80	-60°C → 55	
As welded	SI 307	410	600	42	20°C → 70	-60°C → 50	

### Application Information

#### Welding Positions

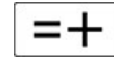


PA

PB

#### Welding Parameters & Efficiency

#### Polarity:



### Packaging Information

Product Code	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
403000AGM2	25 kg	25.60	1	25.60	Craft Bag

### Storage & Re-Drying Information

Generally not required. If required, redry for 1 hour at 110°C. During transportation and storage, it should be ensured that the packaging is not damaged or torn. It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets. It has to be dried at 350°C for 2 hours.