

SIF 502

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

Standards

EN ISO 14174	S A CS 2 Cr DC
TS EN ISO 14174	S A CS 2 Cr DC

Properties and Applications

Calcium-silicate 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. Cr alloy content of the flux prevents Cr loss in stainless steel weld bead during welding. Provides good welding characteristics and easy slag removal even on thin section welding.



Typical Chemical Values of Weld Metal

Welding Flux	Welding Wire	Type of Analysis	C	Si	Mn	Cr	Ni	Mo	Nb	N
SIF 502		Weld Deposit	0.02	0.65	1.00	22.50	9.50	2.70	0.35	0.12
	SI 308L	Weld Deposit	0.02	0.65	1.00	20.00	9.50			
	SI 309L	Weld Deposit	0.02	0.75	1.45	20.50	11.50			
	SI 316L	Weld Deposit	0.02	0.70	1.25	19.00	11.00	2.70		
	SI 347	Weld Deposit	0.04	0.65	0.95	19.50	9.00		0.35	
	SI 2209	Weld Deposit	0.02	0.75	1.10	22.50	9.00	2.50		0.12
	SI 307	Weld Deposit	0.04	0.90	5.00	19.00	8.00			

Typical Mechanical Values of Weld Metal

Test Condition	Welding Wire	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SI 308L	390	565	36	20°C → 80	-60°C → 60	-196°C → 45
As welded	SI 309L	410	560	34	20°C → 70	-60°C → 40	-196°C → 30
As welded	SI 316L	400	570	34	20°C → 70	-60°C → 55	-196°C → 45
As welded	SI 347	430	610	26	20°C → 70	-60°C → 55	-196°C → 35
As welded	SI 2209	590	760	28	20°C → 55	-60°C → 35	
As welded	SI 307	420	610	40	20°C → 60	-60°C → 45	

Application Information

Welding Positions

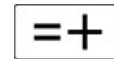


PA

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
403010AGM2	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.