

Classifications
EN ISO 14174

S A FB 2 AC

Characteristics and typical fields of application

Marathon 444 is a highly basic agglomerated welding flux, designed for welding and cladding of nickel-alloys. The weld metals show excellent mechanical properties with high hot cracking resistance.

Flux properties

Polarity	DC+ / AC
Basicity index (Boniszewski)	2.8 (wt%) ; 4.4 (mol)
Grain size (EN ISO 14174)	3 – 16 (0.3 – 1.6 mm)
Apparent density	1.0 kg/dm ³
Redrying	300 – 350°C for 2 – 10 h

Composition of sub-arc welding flux

	CaF ₂	SiO ₂	CaF ₂ +CaO+MgO
wt. %	19	7	61

Typical wires to combine

Name	EN ISO	Class	AWS / SFA	Class
UTP UP 6222 Mo	18274	S Ni 6625 (NiCr-22Mo9Nb)	A5.14 / -5.14	ER NiCrMo-3
Thermanit NiCro 82	18274	S Ni 6082 (NiCr20Mn3Nb)	A5.14 / -5.14	ERNiCr-3
UTP UP 6170 Co	18274	S Ni 6617 (NiCr22Co-12Mo9)	A5.14 / -5.14	ERNiCrCoMo-1
UTP A 759	18274	S Ni 6059 (NiCr23Mo16)	A5.14 / -5.14	ER NiCrMo-13

Packaging

Type	Weight
DRY SYSTEM	25 kg