

**Classifications**
**EN ISO 14174**

S A FB 1 55 AC H5

**Characteristics and typical fields of application**

UV 419 TT-W is an agglomerated fluoride-basic flux for submerged arc welding of unalloyed and low alloyed steel grades. The basic flux has a neutral metallurgical behaviour regarding to Mn and Si, and is mainly recommended for multi-run procedures for relative great wall thickness. Nice flat bead appearance with very good slag detachability, especially in narrow gap applications.

Metallurgically, the flux has been optimised to provide excellent mechanical properties as well after PWHT-duration as also in as welded condition.

**Flux properties**

Polarity	DC / AC
Basicity index (Boniszewski)	2.6
Grain size (EN ISO 14174)	3-20 (0.3 bis 2.0 mm)
Apparent density	1 kg/dm <sup>3</sup>
Flux consumption	0.9 - 1.1 kg flux per kg wire
Redrying	300 – 350°C. min 2 hrs
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100gr (as produced / re-dried ; verified with DC+)

**Composition of sub-arc welding flux**

	SiO <sub>2</sub> +TiO <sub>2</sub>	CaO+MgO	Al <sub>2</sub> O <sub>3</sub> +MnO	CaF <sub>2</sub>
wt. %	15 %	35 %	21 %	26 %

**Typical wires to combine**

Name	EN ISO	Class	AWS / SFA	Class
diamondspark S 55 HP	14171-A	T3	A5.17 / -5.17	EC1
UNION S 2 MO	14171-A	S2Mo	A5.23 / -5.23	EA2
UNION S 3 SI	14171-A	S3Si	A5.17 / -5.17	EH12K
Union S 2 NiMo 1	14171-A	SZ2Ni1Mo0,3	A5.23 / -5.23	ENi1
UNION S 3 NiMo 1	26304-A	S3Ni1Mo	A5.23 / -5.23	EF3
UNION S 2 CRMO	24598-A	S S CrMo1	A5.23 / -5.23	EB2R
diamondspark S 550 HP	14171-A	TZ3Ni1Mo	A5.23 / -5.23	ECNi5
UNION S 2 SI	14171-A	S2Si	A5.17 / -5.17	EM12K

**Packaging**

Type	Weight
DRY SYSTEM	25 kg