

Classification

EN ISO 14174

SA AF 2 Cr DC

Characteristics and typical fields of application

Avesta Flux 801 is a basic, slightly Cr-compensated agglomerated flux. It is primarily designed for welding of high-alloyed stainless steels together with SAW wire Avesta P12, Avesta 904L and Avesta 2205. The flux is also suitable for standard Cr-Ni and Cr-Ni-Mo filler metals with excellent results. It is especially suited for applications where high impact strength values are required.

Flux 801 provides a smooth weld surface, very good welding properties and easy slag removal

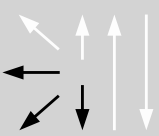
Base materials

Suitable for welding of many stainless steels together with SAW wire Avesta LDX 2101, 2304, 2205, 2507/P100, 904L, P12 und P16, but also with 308L/MVR, 347/MVR, 316L/SKR, 318/SKNb, 309L and P5.

Composition of sub-arc welding flux (wt. %)

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃	CaF ₂
wt.-%	20	26	18	32

Operating data

	Polarity: DC (+) / DC (-)	Basicity index Boniszewski:	1.7 Gew. %
		Bulk density:	1.0 kg/dm ³
		Grain size acc. to EN ISO 14174:	2 – 12 (0.2 – 1.25 mm)
		Flux consumption: (26 V)	0.5 kg Pulver je kg Draht
		(34 V)	0.8 kg Pulver je kg Draht
		Re-drying:	250 – 300 °C, min. 2h

Typical composition of all-weld metal with different wires

Wire	C	Si	Mn	Cr	Ni	Mo	FN
Avesta 316L/SKR	0.02	0.6	1.2	19.5	12.0	2.6	14 (DeLong)
Avesta 2205	0.02	0.7	1.0	23.5	8.0	3.1	50 (WRC-92)
Avesta P12	0.01	0.3	0.1	22.0	Bal.	8.5	-

Wire	Classification of the wire/flux-combination	
	acc. to EN ISO 14343-A	acc. to AWS A5.9
Avesta LDX 2101		
Avesta 2304		
Avesta 2205		
Avesta 2507/P100		
Avesta 904L		
Avesta P12		

Approvals

Wire/flux combination Avesta Flux 805 together with Avesta wires:

TÜV, CE: Avesta 308L/MVR, Avesta 347/MVR, Avesta 2304, Avesta 2205, Avesta 904L

DNV: Avesta 316L/SKR, Avesta 309L, Avesta P5, Avesta 2205

GL: Avesta 2205

RINA: Avesta 2205

LR: Avesta 2205