

AST 347 is an agglomerated submerged-arc welding flux used with austenitic stabilized stainless steel strips, such as SUPRASTRIP 19 9 LNb. The special formula enhances the weld bead profile with excellent and easy slag detachability. The flux is suitable for weld overlay in petrochemical, chemical and nuclear applications. Damp flux should be re-dried at 300-350°C.

Grain size according to EN 760: 2-20.

Classification

EN ISO 14174: S A AB 2

Flux Main Components

Al2O3	29 %
SiO2	25 %
MgO	17 %
CaF2	15 %
CaO	5 %

Boniszewski Basicity 0.8

Chemical analysis (Typical values in %)

		C	Mn	Si	Cr	Ni	Nb	Ferrite
All weld metal	SUPRASTRIP 24 13 LNb	0.05	1.2	0.7	18.5	10.5	0.6	-
All weld metal	SUPRASTRIP 19 9 LNb	0.04	1.2	0.8	19.5	10.2	0.5	8

Redrying

300-350°Cx2-4h

Current Conditions

DC+