

AST 600 is a basic agglomerated submerged-arc welding flux used in combination with high nickel alloyed strip, such as SUPRASTRIP 625. The special formula enhances the weld bead profile with excellent and easy slag detachability. The weld bead shows a very high hot cracking resistance. 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

Al ₂ O ₃	39 %
CaO	19 %
CaF ₂	12 %
SiO ₂	10 %
MgO	7 %
MnO	5 %

Boniszewski Basicity 1.5

Chemical analysis (Typical values in %)

		C	Mn	Si	Cr	Ni	Mo	Nb	Fe
All weld metal	SUPRASTRIP P 625	0.04	1	0.4	19	Rem	8	2.8	12
All weld metal	SUPRASTRIP P 625	0.02	1	0.3	20	Rem	9	3.2	3

Redrying

300-350°Cx2-4h

Current Conditions

DC+