STRONG FLUX - 68X

High Strength Fluoride-Basic SAW Flux for High Tensile Welding Applications



CLASSIFICATION: AWS SFA 5.23 F10AZ WITH HIGH TENSILE WIRES

CHARACTERISTICS

STRONG FLUX 68X is a high basicity fluoride-basic SAW flux specially developed for high tensile strength welding applications requiring superior mechanical performance and excellent weld metal integrity. This flux delivers ultra-clean weld metal, excellent tensile properties, low impurity levels, and a premium silver-finish weld bead, making it ideal for demanding structural and heavy fabrication applications.

APPLICATIONS

Suitable for Heavy structural fabrication, Crane girders and heavy beams, Bridge fabrication, Mining and earthmoving equipment, Pressure vessel fabrication, Offshore structures, High tensile steel fabrication, Heavy engineering industries.

FLUX TYPE - Fluoride Basic

BASICITY INDEX - 2.6 (Boniszewski)

COMPOSITION OF THE FLUX (%)

$SiO_2 + TiO_2$	$CaO + MgO$	$Al_2O_3 + MnO$	CaF_2	S	P
10-20	30-40	15-25	~20	0.035 MAX	0.040 MAX

TYPICAL ALL WELD MECHANICAL PROPERTIES

SAW WIRE	Y.S. MPa	U.T.S. MPa	ELONGATION (L=4D) %	TYPICAL STRENGTH CLASS
EM2	540	660	26	Medium-High
EM3	580	700	24	High
EM4	630	760	22	Higher Strength
EF1	560	680	22	High Strength
EF2	660	780	20	High Tensile
EF3	680	800	18	High Tensile
EF4	700	830	17	Wear/Strength
EF5	725	855	16	Very High Strength
EF6	680	800	17	High Toughness
EG	825	940	15	Ultra High Strength

WELDING PARAMETERS - Current up-to 800 amps, Voltage: 24-34 V, Speed: Up-to 0.60 mts/min.

PACKAGING SPECIFICATION - 25 kg Paper Bag / Vacuum Bag with Plastic liner.

RE-DRYING CONDITION - Recommended at 300°- 350°C for 2 hours.

STRONGWIRE Industries

www.strongwire.in