STRONG FLUX - HR201

High Basicity SAW Flux for Creep Resistant & Heat Resistant Welding Applications

CLASSIFICATION: AWS SFA 5.23 F8P0-EB2, F9P0-EB3, F9P2-EB6, F9P2-EB8, F9P2-EB91

CHARACTERISTICS

STRONG FLUX HR201 is a specialized SAW flux designed for creep and heat-resistant welding, ensuring excellent mechanical properties in both as-welded and post-weld heat-treated conditions. It offers low hydrogen weld deposits, great toughness, stable arc characteristics, and superior mechanical properties after PWHT, making it suitable for critical applications in boilers, pressure vessels, power plants, refineries, and high-temperature services.

APPLICATIONS

Suitable for Boilers, Pressure vessels, Steam pipelines, Refineries, Petrochemical plants, Thermal power plants, Heat exchangers, Reactor vessels, High-temperature service fabrication, Creep resistant alloy steel structures.

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 AFTER PWHT (720-760°C)

SAW WIRE	C	Mn	Si	Cr	Mo	Y.S.	U.T.S.	ELONGATION (L=4D)	PWHT STABILITY
			%			MPa	MPa	%	
EB2	0.08	0.80	0.20	1.25	0.50	500	600	27	VERY GOOD
EB3	0.08	0.80	0.20	2.25	1.05	525	625	25	EXCELLENT
EB6	0.08	0.75	0.20	5.10	0.50	550	650	24	EXCELLENT
EB8	0.08	0.70	0.15	9.10	1.05	625	725	22	SUPERIOR
EB91	0.08	0.65	0.15	9.00	1.05	650	775	20	OUTSTANDING

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