

STRONG FLUX - HR204

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

CLASSIFICATION: AWS SFA 5.23 F9P2-EB6, F9P2-EB8, F9P2-EB91, F9P2-EB92



CHARACTERISTICS

STRONG FLUX HR204 is a specialized ultra high basicity Fluoride-Basic premium SAW flux designed for advanced welding applications requiring exceptional mechanical properties. It offers ultra-low hydrogen weld deposits, superior crack resistance, excellent low-temperature impact toughness, and outstanding metallurgical stability after Post Weld Heat Treatment (PWHT).

APPLICATIONS

Suitable for Thermal power plants, Ultra-supercritical boilers, High-pressure steam pipelines, Refineries and petrochemical plants, Reactor vessels, High-temperature pressure vessels, P91 / P92 critical piping systems, Advanced creep resistant alloy fabrication.

FLUX TYPE - Fluoride Basic

BASICITY INDEX - 2.8 (Boniszewski)

COMPOSITION OF THE FLUX (%)

$\text{SiO}_2 + \text{Al}_2\text{O}_3 + \text{TiO}_2$	$\text{CaO} + \text{MgO} + \text{MnO}$	CaF_2	S	P
25-40	35-50	25-30	0.035 MAX	0.040 MAX

TYPICAL ALL WELD MECHANICAL PROPERTIES AFTER PWHT (720-760°C)

SAW WIRE	C	Mn	Si	Cr	Mo	W	Y.S.	U.T.S.	ELONGATION (L=4D)	PWHT STABILITY
	%						MPa	MPa	%	
EB6	0.08	0.70	0.15	5.10	0.50	-	550	660	26	EXCELLENT
EB8	0.08	0.60	0.15	9.10	1.05	-	625	730	25	SUPERIOR
EB91	0.08	0.50	0.12	9.00	1.05	-	650	775	24	OUTSTANDING
EB92	0.08	0.50	0.12	9.00	0.50	1.80	680	810	24	EXCEPTIONAL

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