STRONG FLUX - LT1

Ultra High Basicity SAW Flux for Cryogenic & Low Temperature Welding Applications

CLASSIFICATION: AWS SFA 5.23 F48P7-ENi1, F48P7-ENi2, F48P7-ENi3, F48P7-ENi5, F48P7-ENiK

CHARACTERISTICS

STRONG FLUX LT1 is a premium agglomerated SAW flux designed for cryogenic and low-temperature steel applications that require high impact toughness. It offers ultra-clean weld metal, low hydrogen deposits, superior notch toughness, stable arc characteristics, and excellent weld integrity, specifically for use with nickel-bearing low-temperature SAW wires.

APPLICATIONS

Suitable for Cryogenic & Low Temperature Service LNG storage tanks, LPG / ammonia vessels, Ethylene service tanks, Refrigeration pressure vessels, Low temperature process piping, Offshore modules, Sub-zero service steel fabrication, Arctic / cold region equipment.

FLUX TYPE - Fluoride – High Basic **BASICITY INDEX - 3.0 (Boniszewski)**

COMPOSITION OF THE FLUX (%)

$SiO_2 + Al_2O_3 + TiO_2$	CaO + MgO + 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	Y.S. MPa	U.T.S. MPa	ELONGATION (L=4D) %	CVN IMPACT -70°C
ENi1	400–470	510–590	≥24%	35–55
ENi2	430–520	540–630	≥24%	45–70
ENi3	450–540	560–660	≥24%	55–85
ENi5	470–560	580–690	≥22%	45–75
ENiK	420–500	530–620	≥23%	40–65

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