

STRONG FLUX - SS60

Stainless Steel & Heat Resistant SAW Flux

Silicon-Manganese Type classified under AWS A5.39/A5.39M
Agglomerated Flux | Neutral to Slightly Alloying



CHARACTERISTICS

STRONG FLUX SS60 is a premium quality Silicon-Manganese type agglomerated SAW flux specially developed for welding stainless steel and heat resistant steel wires. This flux delivers smooth arc characteristics, stable slag detachability, bright weld appearance, and balanced alloy recovery. It is designed for producing clean weld deposits with low carbon pickup and controlled chromium burn-off compensation.

APPLICATIONS

Suitable for Stainless Steel Fabrication of Tanks & vessels, Chemical equipment, Dairy & food plants, Brewery piping, Pharmaceutical reactors.

FLUX TYPE - Silicon-Manganese

BASICITY INDEX - 1.8 (Boniszewski)

COMPOSITION OF THE FLUX (%)

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	S	P
5-10	6-10	30-40	40-50	0.035 MAX	0.040 MAX

TYPICAL COMPARITIVE ANALYSIS WITH STAINLESS STEEL WIRES

SAW WIRE	STRUCTURE TYPE	Y.S. (MPa)	U.T.S. (MPa)	ELONGATION (L=4D) %	KEY FEATURE
E308L	Austenitic	320-420	540-660	30-40	General stainless
E309L	Austenitic	360-460	560-700	28-38	Dissimilar joining
E316L	Austenitic	330-440	540-680	30-40	Better corrosion resistance
E310	Austenitic Heat Resistant	340-460	560-720	28-38	High temperature service
E347	Stabilized Austenitic	340-450	560-700	28-38	Elevated-temp stability
E410	Martensitic	450-650	650-850	12-22	High hardness / needs control
E2209	Duplex	500-650	700-900	22-32	High strength + corrosion
E2594	Super duplex	550-750	780-980	18-28	Very high strength + PREN

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