# LEXAL F 500

FLUX AGLOMERAT PENTRU SUDARE / SUBARC AGGLOMERATED FLUX

**CLASIFICARE/ *STANDARDS***

**EN 760 :** S A FB 2 53 AC

**AUTORIZARI / *APPROVALS***

with LEXAL S 22.9.3N **: RINA, GL, DNV, LRS, BV**
with AS 309L Mo **: RINA**

**CARACTERISTICI PRINCIPALE**

Flux aglomerat bazic pentru sudarea otelurilor inoxidabile stabilizate cu titan si niobiu si pentru sudarea otelurilor duplex. Poate fi utilizat pentru sudarea multistrat in cazul sudurilor cap la cap, sudurilor de colt si in cazul incarcarilor. Permite atingerea unor viteze mari de sudare in cazul tablelor subtiri, in una sau mai multe treceri. Zgura se detaseaza foarte usor chiar si atunci cand este calda.

***MAIN FEATURES***

*Agglomerated basic flux for welding stainless steels, also Ti or Nb stabilized types and duplex . Suitable for multipass welding in fillet weld, butt weld and weld overlay. It allows high welding speeds on thin thicknesses in single or multipass. Good slag removal even when hot.*

**DOMENII DE APLICATIE**

Industria alimentara
Industria chimica si petrochimica
Rezervoare, recipienti sub presiune
Incarcare / Placare

***MAIN APPLICATIONS***

*Food industry*
*Chemical and petrochemical applications*
*Tanks, pressure vessels*
*Facing / Weld overlay*

**CONSTITUENTI PRINCIPALI % (Valori tipice) / *MAIN CONSTITUENTS % (Typical values)***

Ca0 + CaF2 + Mg0 = 54 Si02 = 7

Al203 = 37

Indice de bazicitate / *Basicity Index*: 2.2 ca.

(in acord cu Boniszewski / *according to Boniszewski)*

**CURENT - CALCINARE**

DC sau AC,pana la 900 A. (DC+, CV pentru valori mici ale curentului). 350° C pentru minim 2 ore

***CURRENT - REBAKING***

*DC or AC, up to 900 A. (DC+, CV for low current)*
*350° C for 2 hours min.*

**ANALIZA CHIMICA A METALULUI DEPUS % / *ALL - WELD METAL CHEMICAL ANALYSIS %***

| Sarma/*WIRE* | C | Mn | Si | P | S | Cr | Ni | Mo | Nb | Cu | N | Ferrite |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **AS 308L** | ≤ 0.04 | 1 - 2 | 0.3 - 0.8 | ≤ 0.03 | ≤ 0.02 | 18 - 21 | 9 - 11 | - | - | ≤ 0.35 | - | - |
| **AS 309L** | ≤ 0.04 | 1 - 2 | 0.3 - 0.8 | ≤ 0.03 | ≤ 0.02 | 22.5 - 24 | 12.5 - 14 | - | - | ≤ 0.35 | - | - |
| **AS 316L** | ≤ 0.04 | 1 - 2 | 0.3 - 0.8 | ≤ 0.03 | ≤ 0.02 | 17.5 - 19.5 | 11 - 13 | 2 - 3 | - | ≤ 0.35 | 0.04-0.06 | - |
| **AS 347** | ≤ 0.08 | 1 - 2 | 0.3 - 0.8 | ≤ 0.03 | ≤ 0.02 | 18 - 21 | 9 - 11 | - | (4) | ≤ 0.35 | 0.04-0.06 | - |
| **LEXAL S 22.9.3N** | ≤ 0.04 | 1.1 - 1.5 | 0.5 - 0.8 | ≤ 0.03 | ≤ 0.02 | 21.5 - 23.5 | 7.5 - 9.5 | 2.5 - 3.5 | - | - | 0.12 - 0.18 | (1)(2)(3) |

(1) In acord cu ESPY AWS A5.4-92: 40% (valoare tipica) 35 - 65% (valoare garantata)
*According to ESPY AWS A5.4-92: 40% (typical value) 35 - 65% (guaranteed values)*
(2) PREN (Pitting Resistant Equivalent Number) = % Cr + 3.3 x % Mo + 16 x % N = 35 (Valoare tipica / *typical value*).
(3) Pitting Corrosion Test (according to ASTM G48 Method A / condition test: 24h exposure at +20° C)
(4) Nb: 10 x % C min. - 1.0% max.

**CARACTERISTICI MECANICE ALE METALULUI DEPUS / *ALL WELD METAL MECHANICAL PROPERTIES***

| Sarma/WIRE | Trat. termic/*Heat treatment* | Rm N/mm² | Rs N/mm² | E % 5d | Kv J -50° | Kv J -196°C |
|---|---|---|---|---|---|---|
| **AS 308L** | Stare sudata/*As welded* | ≥ 520 | ≥ 340 | ≥ 35 | - | ≥ 50 |
| **AS 309L** | " " " " | ≥ 520 | ≥ 380 | ≥ 30 | - | ≥ 70 |
| **AS 316L** | " " " " | ≥ 520 | ≥ 440 | ≥ 30 | - | ≥ 40 |
| **AS 347** | " " " " | ≥ 520 | ≥ 430 | ≥ 30 | - | ≥ 35 |
| **LEXAL S 22.9.3N** | " " " " | ≥ 740 | ≥ 570 | ≥ 26 | ≥ 60 | - |

**AMBALARE STANDARD / *STANDARD PACKAGING***

| | | | | | |
|---|---|---|---|---|---|
| Sac/*Bag* | 25 Kg | 3310618 | | | |