



INCOFLUX[®] 5 Submerged Arc Flux

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INCOFLUX 5 is an agglomerated Submerged Arc Welding (SAW) Flux designed for wire welding with MONEL Filler Metal 60. Typical applications are groove welding MONEL alloy 400 to itself and to ferritic materials. A major application is for overlaying carbon steels with the corrosion resistant MONEL Filler Metal 60 .

Welding Parameters: Groove and Overlay Welding using DCEP current and Stringer beads.

Diameter	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Depth
0.062 in. 1.6 mm	260-280	30-33	8-11 in./min. 200-280 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	250-300	32-35	8-11 in./min. 200-280 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

Overlay Welding with Oscillation: Use DCEN current and Oscillation Frequency of 50-70 cycles/min for 0.062 in. and 35-60 for 0.093 in.

0.062 in. 1.6mm	260-280	32-35	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	300-400	34-37	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

Specification

EN 760 - S A FB2

Particle Size

Tyler Sieves: 10 x 60 Mesh (0.25 mm x 2.0 mm), EN 760 2-20

Packaging

60 pound (27.22 kg) Polyethylene Bucket with a hermetically sealed lid that has a rubber gasket seal.

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