



INCOFLUX[®] SAS1 Submerged Arc Strip Flux

INCOFLUX SAS1 Submerged Arc Strip Welding (SASW) Flux is designed for strip welding with INCONEL Weldstrips 82 and 625. It is used for overlaying carbon steels with the two alloys. The agglomerated, neutral flux provides the ability to achieve a chemical composition nearly matching the Weldstrip in the second layer. The smooth, tight ripples and excellent wetting provide the ability to make flat overlays that may be used in the as-welded condition.

Welding Parameters: Overlay Welding using DCEP current.

Strip Size	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Depth
0.5 mm x 60 mm 0.02 in. x 2.36 in.	700-900	25-28	4-5 in./min. 100-125 mm/min.	3/4-1 in. 19-25 mm	3/4-1 1/2 in. 19-38 mm
0.5 mm x 30 mm 0.02 in. x 1.18 in.	300-450	25-28	4-5 in./min. 100-125 mm/min.	3/4-1 in. 19-25 mm	3/4-1 1/2 in. 19-38 mm

Specification

EN 760 - S A AF2

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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