

LA436 FLUX

Product description

Neutral, aluminate basic, agglomerated flux.

Basicity Index (according to Boniszewski) is ~1.6.

Specifications

BS EN 760 S A AB 1 67 AC H5

ASME IX Qualification

QW432 F-No -, QW442 A-No -.

Materials to be welded

The base materials to be welded include ASTM A335 P11, P22 and P36.

Applications

The LA436 flux is designed for welding low alloy and creep resisting CrMo steels (eg. data sheets A-12, A-13 and A-23). LA436 flux is suitable for joining and surfacing. LA436 shows a silicon pick-up of ~0.3% and manganese pick-up of ~0.4% with a 1%Mn wire (in accordance with BS EN 760).

Welding guidelines

The appropriate preheat or interpass temperature controls will be dependent on the material being welded, guidelines can be found on the data sheet for the

appropriate wire. PWHT recommendations, if required, will also be found on the appropriate wire data sheet.

Typical parameters

Current: DC or AC; DC+ operation is preferred.
Suitable for single or tandem wire, with a current carrying capacity of 700A.

Typical parameters for a 2.4mm wire are:
300-500A, 28-36V, 350-700mm/min travel speed.

Packaging data

Metrode LA436 flux is supplied in sealed moisture resistant 25kg metal drums.

Storage

Preferred storage conditions for open drums: <60%RH, >18°C.
If flux has become damp or has been stored for a long period, it should be redried in the range 250-400°C for 1-2 hours.

Fume data

SAW fume is negligible.

Typical weld deposit analysis, wt%

Wire	C	Mn	Si	S	P	Cr	Ni	Mo
1NiMo	0.06	1.9	0.5	<0.01	<0.02	--	0.9	0.5
1CrMo	0.08	1.1	0.4	<0.01	<0.02	1.1	--	0.5
2CrMo	0.08	0.8	0.4	<0.01	<0.02	2.1	--	1.0

Typical Mechanical properties (PWHT)

Wire	Tensile strength, MPa	0.2% proof stress, MPa	Elongation on 4d, %	Impact energy, J
1NiMo	680	560	30	140J at +20°C
1CrMo	620	535	25	>100J at +20°C
2CrMo	640	560	24	>100J at +20°C