

**Technical  
data sheet**

080122MBA

**FLUX**  
**WAF 325****CLASSIFICATION**

EN ISO 14174

S A AB 1 65 DC H5

**DESCRIPTION**

- WA FLUX 325 (WAF 325) is a basic agglomerated flux for submerged arc welding, cladding and hardfacing with cored wires
- Neutral action on weld metal chemistry
- Easy slag removal, even in narrow preparations
- Good surface appearance with excellent wetting at the weld toes
- Suitable for:
  - ✓ Non-stabilised austenitic stainless steels
  - ✓ Martensitic and ferritic stainless steels
  - ✓ An exhaustive range of WA hardfacing wires

**CHEMICAL COMPOSITION**

|                                      |        |
|--------------------------------------|--------|
| CaF <sub>2</sub>                     | 22 %   |
| SiO <sub>2</sub> + TiO <sub>2</sub>  | 20 %   |
| CaO + MgO                            | 37.5 % |
| Al <sub>2</sub> O <sub>3</sub> + MnO | 18 %   |
| K <sub>2</sub> O + Na <sub>2</sub> O | 2.5 %  |

**FLUX CHARACTERISTICS**

|                |   |
|----------------|---|
| Current type   | DC  |
| Granulometry   | 3-20 (8 x 48 Tyler mesh)  |
| Basicity index | 2.2 according to Boniszewski  |
| Re-drying      | the flux can be stored up to three years in a dry room.<br>If the flux has taken up moisture, it is recommended to dry it at 350-400°C during minimum two hours |

**FLUX CONSUMPTION**

| Voltage | Kg flux/kg wire |
|---------|-----------------|
| 26V     | 0.7             |
| 29V     | 0.9             |
| 32V     | 1.1             |
| 35V     | 1.3             |

**PACKAGING**

25 kg aluminium lined polyethylene moisture resistant bags.  
Other packaging: please consult us