Marathon 431

SAW flux, aluminate-basic, stainless steel

Classification
EN ISO 14174
SA FB 2 DC

Characteristics and typical fields of application
Marathon 431 is a fluoride-basic agglomerated flux for submerged arc welding of CrNi(Mo) stainless steel grades. The flux gives a nice bead appearance without any slag residues. The flux can be applied in multi-pass and single pass welding procedures and has also very good welding properties in fillet welds. It provides a high degree of purity in the weld metal and provides good mechanical properties with good corrosion resistance. The flux does not have a Cr-support.

Flux properties	
Grain size (EN ISO 14174)	4–14 and 4-16 (0.4–1.4 and 0.4-1.6 mm)
Polarity	DC+
Basicity (Boniszewski) wt%	2.2
Redrying conditions	300° - 350, min 2 hrs

Composition of sub-arc welding flux (weight %)		
SiO_2	Al_2O_3	CaF_2
10 %	38 %	50 %

Typical wires to combine		
SAW wires	**AWS A5.9**	**EN ISO 14343-A**
Thermanit JE-308L	ER308L	S 19 9 L
BÖHLER EAS 2-UP (LF)	ER308L	S 23 12 L
Thermanit GE-316L	ER316L	S 19 12 3 L
Thermanit H-347	ER347	S 19 9 Nb
Thermanit A	ER318	S 19 12 3 Nb
Thermanit 25/14 E 309L	ER309L	S 23 12 L
Thermanit 22/09	ER2209	S 22 9 3 N L
Thermanit 25/09 CuT	ER2594	S 25 9 4 N L

Packaging	
Type	**Weight (kg)**
PE-BAG	25 kg
Metal can	30 kg

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.