



Agglomerated Flux for Submerged Arc Welding

Rev 7 Oct'13

SUPERSHIELD SS

Description	<ul style="list-style-type: none">Agglomerated fluoride-basic flux
	<ul style="list-style-type: none">Universal flux for welding of Stainless & Heat Resistant Steels
	<ul style="list-style-type: none">Neutral behaviour in terms of C, Cr, Ni & Mo pick-up or burn out
	<ul style="list-style-type: none">Can be used with low carbon, stabilized & Duplex Stainless Steels
	<ul style="list-style-type: none">Suitable for AC / DC , Single , Multiwire
	<ul style="list-style-type: none">For Pressure Vessel, Structural, Pipe and Offshore items
	<ul style="list-style-type: none">Equally suitable for joint welding and weld overlay
	<ul style="list-style-type: none">Weld Metal has low Sulphur
	<ul style="list-style-type: none">Weld metal has good impact toughness down to Sub zero temp.
	<ul style="list-style-type: none">Excellent slag detachability
	<ul style="list-style-type: none">Smooth side wall wetting and weld bead finish
	<ul style="list-style-type: none">Usable for welding of thick joints with narrow groove

Grain Size	<ul style="list-style-type: none">0.2 to 2 mm
Redrying	<ul style="list-style-type: none">300 – 350 deg C 1 hour
Basicity	<ul style="list-style-type: none">3
Packing	<ul style="list-style-type: none">30kgs HM HDPE Moisture proof containers

Typical analysis of weld metal with various electrodes

Wire	C %	Cr %	Ni %	Mo %	Nb %	Mn %	S %
Superarc SS 308L	0.032	19	9.15	-	-	1.85	0.004
Superarc SS 347	0.065	19	9.50	-	> 8xC%	1.5	0.006
Superarc SS 316L	0.035	18	11.50	2.5	-	1.5	0.006
Superarc SS 309L	0.035	23	12.50	-	-	1.5	0.006
Superarc SS 2209	0.035	22	8.50	3.0	-	1.0	0.006

We can supply wires & fluxes to stringent specifications for welding of various materials:
Steels (Carbon, Carbon Manganese, Carbon – Moly, Low Alloy, High Tensile, Stainless),
Nickel, Aluminium, Copper & their alloys by TIG / MIG / MAG /SA Processes

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