

Classifications

unalloyed

EN ISO 14174:

SAAR 1 76 AC H5

Characteristics and field of use

UV 305 is an agglomerated flux of aluminate-rutile type for joining and surface welding. Suited for direct and alternating current. The flux is suited for butt welding in two-run technique and for sheet thickness up to 10 mm for fillet welding. It is especially suited for welding tube walls.

Suited sub-arc wires:

Union S 2, S 2 Si, S 2 Mo and for boiler walls also Union S 2 CrMo, S 1 CrMo 2, Union S P24. It has outstanding good slag detachability (even in narrow grooves) and allows high welding speed.

Composition of Sub-arc Welding FluxSiO₂+TiO₂Al₂O₃+MnOCaF₂+CaO+ MgO

30

55

8

Operating data

Polarity = - / ~

basicity acc. Boniczewski: 0,7 Mol.% 0,6 weight %
 grain size acc. EN ISO 14174: 4 - 14 (0,4-1,4 mm)
 re-drying: 300-350 C, 2 h

TÜV approvals (for membrane walls)

Union S 2 Mo, Union S 2 CrMo, Union S 1 CrMo2, Union SP 24