

Classifications	unalloyed	
EN ISO 14174:		
SAAR 1 77 AC H5		


Characteristics and field of use

UV 306 is an agglomerated flux designed for joining applications on general-purpose structural and pipe steels. Suitable for use on DC and AC. For single- and multi-wire welding with high welding speed using the two-run technique as well as for fillet welding. Very good slag removability.

Composition of Sub-arc Welding Flux

SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaF ₂ + CaO+MgO	
24	50	14	

Operating data

	Polarity = - / ~	basicity acc. Boniczewski:	0,8 Mol.%	0,6 weight %
		grain size acc. EN ISO 14174:	3 - 16 (0.3 - 1.6 mm)	
		re-drying:	300-350 C, 2 h	

Typical analysis for wire and weld metal in wt. %:

Designation	C	Si	Mn	Mo	EN ISO 14171 AWS A5.17 – SFA 5.17 AWS A5.23 – SFA 5.23
Union S 2 Weld metal	0,10 0,06	0,10 0,60	1,00 1,40		S 42 3 AR S2 F7A2-EM12
Union S 2 Mo Weld metal	0,10 0,06	0,10 0,60	1,00 1,40	0,50 0,45	S 46 2 AR S2Mo F8A2-EA2-A2
Union S 2 Si Weld metal	0,10 0,06	0,30 0,75	1,00 1,60		S 42 2 AR S2Si F7A2-EM12K
Union S 3 Weld metal	0,12 0,07	0,10 0,60	1,50 1,60		S 42 3 AR S3 F7A2-EH10K