INCOFLUX® 7 Submerged Arc Flux

INCOFLUX 7 Submerged Arc Flux (SAW) is an agglomerated flux designed for wire welding with INCONEL Filler Metal 625, a corrosion resistant Nickel-Chromium-Molybdenum alloy. Typical applications are groove welding INCONEL alloy 625 and INCOLOY alloy 825 to themselves and to ferritic materials. The flux and wire combination is used for welding a range of corrosion resistant, molybdenum containing alloys such as 904L, 316, 317, and duplex stainless steels. One major application is for overlaying carbon steels with the corrosion and oxidation resistant INCONEL Filler Metal 625.

Welding Parameters: Groove and Overlay Welding Using DCEP current with stringer beads.

Diameter	Amperes	Volts	Travel Speed	Extension	Flux Burden
0.062 in. 1.6 mm	240-290	20-33	8-11 in/min. 200-280 mm/min	7/8-1 in 22-25 mm	1/2-1 in 13-25 mm
0.093 in. 2.4 mm	250-300	30-33	8-11 in./min. 200-280 mm	7/8-1 in. 22-25 mm	3/4-1-1/4 in 19-32 mm
Overlay Welding with Oscillation: Use DCEN current and Oscillation Frequency of 50-70 cycles/min for 0.062 and 35-60 for 0.093.					
0.062 in. 1.6mm	240-260	32-34	4 in/min. 100 mm/min	7/8-1 in. 22-25 mm	1/2-1 in. 13-25 mm
0.093 in. 2.4 mm	300-400	34-37	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

Storage and Drying Conditions

The flux in unopened containers can be stored indefinitely . Flux that has been exposed to possible moisture pick-up can be re-dried at 500°F. for 2 hours or 600° for one hour.

Particle Size

Tyler Mesh: 10 x 100 Mesh

Packaging

60 pound polyethylene bucket with a lid hermetically sealed with a rubber gasket.