



## INCOFLUX<sup>®</sup> ESS2 Electroslag Strip Flux

**INCOFLUX ESS2 Electroslag** Strip Welding (ESSW) Flux is designed for strip welding with INCONEL Weldstrip 52M and 52MSS. It is used for overlaying carbon steels with these two alloys. The agglomerated, neutral flux provides the ability to achieve a chemical composition nearly matching the Weldstrip in the second layer. The smooth, tight ripples and excellent wetting provide the ability to make flat overlays that may be used in the as-welded condition.

**Welding Parameters:** Overlay Welding using DCEP current.

Strip Size	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Depth
0.5 mm x 60 mm 0.02 in. x 2.36 in.	1100-1300	23-24	6-7 in./min. 150-175 mm/min.	3/4-1 in. 19-25 mm	3/4-1 1/2 in. 19-38 mm
0.5 mm x 30 mm 0.02 in. x 1.18 in.	600-700	23-24	6-7 in./min. 150-175 mm/min.	3/4-1 in. 19-25 mm	3/4-1 1/2 in. 19-38 mm

**Specification**

EN 760 - S A AF2

**Particle Size**

Tyler Sieves: 10 x 60 Mesh (0.25 mm x 2.0 mm), EN 760 2-20

**Packaging**

60 pound (27.22 kg) Polyethylene Bucket with a hermetically sealed lid that has a rubber gasket seal.

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