



## INCOFLUX<sup>®</sup> 9 Submerged Arc Flux

**INCOFLUX 9** is a fused Submerged Arc Welding (SAW) Flux designed for wire welding with INCONEL Filler Metal 625 and INCO-WELD C276 Filler Metal corrosion resistant nickel-chromium-molybdenum alloys. The main application for this flux is for the groove welding of 9% Ni steels used in the production of LNG storage tanks. The flux provides optimum operability and weld bead profile in the horizontal (2G) and flat (1G) positions. The flux can also be used for the groove and overlay welding using austenitic stainless steel alloy filler metals.

**Welding Parameters:** Groove and Overlay Welding using DCEP current and Stringer beads. Can also be welded using AC.

Diameter	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Depth
0.062 in. 1.6 mm	240-290	30-33	8-11 in./min. 200-280 mm/min.	3/4-7/8 in. 19-22 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	250-300	30-33	8-11 in./min. 200-280 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm

**Overlay Welding with Oscillation:** Use DCEN current and Oscillation Frequency of 50-70 cycles/min for 0.062 in. and 35-60 for 0.093 in.

0.062 in. 1.6 mm	240-260	32-34	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 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

### Specification

EN 760 - S F CS2

### Particle Size

Tyler Mesh: 10 x 150 Mesh (0.11 mm x 2.0 mm), EN 760 1-20

### Packaging

44 pound (20.00 kg) Polyethylene Bags.

**INCOFLUX<sup>®</sup> 9 Submerged Arc Flux**