



INCOFLUX[®] ESS4 Electroslag Strip Flux

INCOFLUX ESS4 Electroslag Strip Welding (ESSW) Flux is designed for strip welding with the INCONEL Weldstrips 622, 625, INCO-WELD C-276 and 686CPT. It is used for electroslag overlaying of carbon steels with these alloys. The agglomerated, neutral flux and the electroslag process provide the ability to achieve a low dilution 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. The silicon pick-up in the weld is less than 0.2%.

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 FB2

Particle Size

Tyler Mesh: 12 x 68 Mesh (0.2 mm x 1.7 mm), EN 760 2-16

Packaging

55 pound (25 kg) Polyethylene Bags.