



INCOFLUX[®] NT110 Submerged Arc Welding Flux

INCOFLUX NT110 is an agglomerated Submerged Arc Welding (SAW) Flux for wire welding with MONEL Filler Metal 60 (70% Ni, 30% Cu) and MONEL Filler Metal 67 (70% Cu, 30% Ni). Typical applications with MONEL Filler Metal 60 are groove welding MONEL alloy 400 to itself and to ferritic materials. A major application is for overlaying carbon steels with the corrosion resistant MONEL Filler Metal 60.

The flux is used with MONEL Filler Metal 67 to join Copper-Nickel alloys (90/10, 80/20 and 70/30). Overlays on ferritic steels require a buffer layer of Nickel 61 or MONEL 60.

Welding Parameters: Groove and Overlay Welding using DCEP current and Stringer beads.

| Diameter | Amperes | Volts | Travel Speed | Extension Stick-Out | Flux Depth |
|---------------------|---------|-------|----------------------------------|-----------------------|---------------------------|
| 0.062 in. 1.6 mm | 260-280 | 30-33 | 8-11 in./min. 200-280 mm/min. | 7/8-1 in. 22-25 mm | 3/4-1 1/2 in. 19-25 mm |
| 0.093 in. 2.4 mm | 300-350 | 32-35 | 8-11 in./min. 200-280 mm/min. | 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 in. and 35-50 for 0.093 in.

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|---------------------|---------|-------|---------------------------|-----------------------|---------------------------|
| 0.062 in. 1.6 mm | 260-280 | 32-35 | 4 in./min. 100 mm/min. | 7/8-1 in. 22-25 mm | 1/2-1 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 A FB2

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.