

## INCOFLUX® NT120 Submerged Arc Welding Flux

**INCOFLUX NT120** is an agglomerated Submerged Arc Welding (SAW) Flux for wire welding with the corrosion resistant nickel-chromium-molybdenum-tungsten alloys such as INCONEL Filler Metal 622, INCO-WELD C-276 Filler Metal, and INCO-WELD 686CPT Filler Metal. Typical applications are the groove welding of nickel alloys of a similar composition (eg. C-22, C-276, 59, 686). The flux and wire combinations are also for welding stainless steels (eg. 6% Mo and duplex stainless steels, etc.) and nickel alloys where enhanced weld metal corrosion properties are required through the Ni-Cr-Mo-W filler metals.

**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.<br>1.6 mm | 240-290 | 30-33 | 8-11 in./min.<br>200-280 mm/min. | 7/8-1 in.<br>22-25 mm | 3/4-1 in.<br>19-25 mm     |
| 0.093 in.<br>2.4 mm | 250-300 | 30-33 | 8-11 in./min.<br>200-280 mm/min. | 7/8-1 in.<br>22-25 mm | 3/4-1 1/4 in.<br>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.

|                     |         |       |                           |                       |                           |
|---------------------|---------|-------|---------------------------|-----------------------|---------------------------|
| 0.062 in.<br>1.6 mm | 240-260 | 32-34 | 4 in./min.<br>100 mm/min. | 7/8-1 in.<br>22-25 mm | 3/4-1 in.<br>19-25 mm     |
| 0.093 in.<br>2.4 mm | 300-400 | 34-37 | 4 in./min.<br>100 mm/min. | 7/8-1 in.<br>22-25 mm | 3/4-1 1/4 in.<br>19-32 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.

