

## INCOFLUX<sup>®</sup> SAS2 Submerged Arc Strip Flux

**INCOFLUX SAS2** Submerged Arc Strip Welding (SASW) Flux is designed for strip welding with INCONEL Weldstrips 52, 52M and 52MSS . It is used for overlaying carbon steels with the 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.	700-900	25-28	4-5 in./min. 100-125 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.	300-450	25-28	4-5 in./min. 100-125 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.