

Flux

Classification

Flux 802	EN 760 :	S A CS 1 55 DC H5	
Flux/wire	Flux cored hardfacing wire		no AWS and EN classification
	Solid hardfacing wire		

General description

Neutral flux for hardfacing applications in combination with flux cored wire as Lincore 102W, Lincore 423L and Lincore 423Cr.

Also suitable for hardfacing applications with solid wires

Weld metal with min. 0.2% Si and additional V, Nb, Ti and higher Cr-content

Excellent slag removal and good bead appearance

Very suitable for hardfacing applications on plate and caster rolls

Chemical composition (w%), typical, all weld metal

Wire grade	C	Mn	Si	Cr	Ni	Mo	V	W
LINCORE 102W	0.28	1.5	0.4	6.5		1.0	0.15	1.0
LINCORE 423L	0.15	1.2	0.4	11.5	20	1.0	0.15	
LINCORE 423Cr	0.15	1.2	0.4	13.5	2.0	1.0	0.15	

Mechanical properties, all weld metal

Wire grade	2 hours postweld tempering at					
	AW	426°C	482°C	538°C	593°C	649°C
LINCORE 102W	51	50	50	51	40	35
LINCORE 423L	43	42	46	38	33	32
LINCORE 423Cr	AW	46	45	46	38	32

Hardness: HRc in 6 layer hardfacing application

802: rev. EN 21

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

Packaging and available sizes

Unit	Net weight (kg)
Bag	25
Sahara ReadyBag™ (SRB)	25