

ST65

CATEGORY	SAW Arc Submerged																																								
TYPE	Semi basic SAW flux with very low hydrogen content suitable for single and multilayer welding.																																								
APPLICATIONS	Spiral piping, pipe welding, vessel, offshore fundamentals, bridge construction, narrow gab welding.																																								
PROPERTIES	Neutral semi basic flux suitable for a weight range of wire combinations including multi layer welding in general construction with good cold tough properties down to -40 degrees Celsius.																																								
	Basicity according to Boniszewski: Grain size according DIN EN 760:				~1.7 3 - 20																																				
CLASSIFICATION	EN ISO	14174: SA AB 1 67 AC(D) H5																																							
SUITABLE FOR	S355, S420, S460, X65, X70, 15Mo3, Hardox 400, Dilimax.																																								
APPROVALS	DB, Lloyds, DNV, TUV..																																								
WELDING POSITIONS:																																									
FILLER METAL ANALYSIS % (TYPICAL VALUES)	<table border="1"> <thead> <tr> <th>SiO₂+TiO₂</th> <th>CaO + MgO</th> <th>Al₂O₃+ MnO</th> <th>CaF₂</th> <th>K₂O+Na₂O</th> <th>S</th> <th>P</th> </tr> </thead> <tbody> <tr> <td>20</td> <td>30</td> <td>26</td> <td>16</td> <td>2,5</td> <td><0.015</td> <td><0.015</td> </tr> </tbody> </table>						SiO ₂ +TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	K ₂ O+Na ₂ O	S	P	20	30	26	16	2,5	<0.015	<0.015																					
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	* For both as welded condition and annealed at 920°C.																																								
REDRYING TEMPERATURE	300-350°C / 1-2hr																																								
PACKING	25 kg sealed metal buckets / 25 kg bags.																																								