

# Flux 807

For welding with submerged arc wire such as Avesta Welding

308L/MVR, 347/MVNB, 316L/SKR, 318/SKNb, 309L and P5 but also with LDX 2101, 2304, 2205 and 2507/P100.

## Standard designation

EN 760 SA FB 2 64 DC

## Characteristics

AVESTA Flux 807 is a basic non-alloyed agglomerated flux. It is a general-purpose flux designed for butt welding with standard Cr-Ni and Cr-Ni-Mo fillers. It can also be used for cladding unalloyed or low-alloy steel.

Flux 807 provides neat weld surfaces, very good welding properties and easy slag removal.

- Bulk density: 1.1 kg/dm<sup>3</sup>
- Basicity index: 2.7 (Boniszewski)
- Flux consumption: 0.5 kg flux/kg wire (26 V)  
0.8 kg flux/kg wire (34 V)

## Welding data

Diameter mm	Current A	Voltage V	Speed cm/min
2.40	300 – 400	29 – 33	40 – 60
3.20	350 – 500	29 – 33	40 – 60
4.00	400 – 600	30 – 36	40 – 60

## Flux care

The flux should be stored indoors in a dry place. Moist flux can be redried at 250 – 300°C for 2 hours. Both heating and cooling must be carried out slowly.

## Chemical composition, all weld metal (typical values, %)

SA wire	C	Si	Mn	Cr	Ni	Mo	FN
308L/MVR	0.02	0.6	1.2	19.5	10.0	–	8 <sup>1)</sup>
316L/SKR	0.02	0.6	1.2	18.5	12.0	2.6	8 <sup>1)</sup>

<sup>1)</sup> According to DeLong.

## Mechanical properties

Typical values (IIW) in combination with

SAW wire	308L/MVR	316L/SKR
Yield strength R <sub>p0,2</sub>	380 N/mm <sup>2</sup>	380 N/mm <sup>2</sup>
Tensile strength R <sub>m</sub>	550 N/mm <sup>2</sup>	540 N/mm <sup>2</sup>
Elongation A <sub>5</sub>	40 %	40 %
Impact strength KV		
+20°C	100 J	90 J
-196°C	30 J	30 J

## Approvals

308L/MVR	• CE	• TÜV	
347/MVNB	• CE	• TÜV	
316L/SKR	• CE	• TÜV	
318/SKNb	• CE	• TÜV	
2205	• CE	• GL	• TÜV