

For welding with submerged arc wire such as:

Avesta Welding
308L/MVR, 347/MVNB, 316L/SKR, 318/SKNb, 309L and P5

CHARACTERISTICS

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-alloyed steel.

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

- Bulk density: 1.1 kg/dm³
- Basicity index 2.7 (according to Boniszewski)
- Flux consumption: 0.5 kg flux/kg wire (26 V)
0.8 kg flux/kg wire (34 V)

Welding data

Wire diam. 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

For further recommendations, please contact Avesta Welding.

Flux care

AVESTA FLUX 807 is supplied in plastic-lined paper bags containing 25 kg. 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.

Standard designation

EN 760 SA AB 2 DC

Typical weld metal composition, %

	C	Si	Mn	Cr	Ni	Mo	FN
308L/MVR	0.02	0.6	1.2	19.5	10.0	-	8 ⁽¹⁾
316L/SKR	0.02	0.6	1.2	18.5	12.0	2.6	8 ⁽¹⁾

1.Ferrite according to Schaeffler-DeLong

Mechanical properties – Typical values (IIW)

	308L/MVR	316L/SKR
Yield strength, R _{p0.2}	380 N/mm ²	380 N/mm ²
Tensile strength, R _m	550 N/mm ²	540 N/mm ²
Elongation, A ₅	40 %	40 %
Impact strength, KV	+20°C	100 J
	-196°C	30 J

Approvals: -