



PITTARC FL188F



Main features: Agglomerated semi-basic welding flux suitable for carbon alloy steel welding in single and multipass technique and in single or multi-wire application. The weld metal produced in combination with corresponding wire electrodes produces good mechanical properties and in particular high toughness at low temperature. Good slag removal in fillet and groove welds. The main applications of this flux are: boilers works, pipes, ship-building, structural steelworks, tanks and pressure vessels, offshore applications, etc.

Basicity index	about 1,5 (according to Boniszewski)		
Classification	ISO 14174	: S A AB 1 67 AC H5	
	ISO 14171	: S 35 2 AB S1 – S 38 4 AB S2 – S 38 4 AB S2Si - S 46 4 AB S3Si S 46 3 AB S3Ni1Cu (SH2) - S 46 2 AB S2Mo – S 50 3 AB S4Mo S50 4 AB S3Ni1Mo0,2	
	AWS A5.17	: F6AP4-EL12 (S1) - F7AP4-EM12K (S2) - F7AP4-EM12K (S2Si) F7AP5-EH12K (S3Si)	
	AWS A5.23	: F8A4-EA2-A4 (S2Mo) – F8P2-EA2-A2 (S2Mo) –F8A4-EA4-A3 (S3Mo) F8A2-EG-G (SH2) – F8A5-EG-G (S3Ni1Mo0,2)	
Current	DC or AC, in single or multi-wires up to 1200 Amp. each wire electrode		
Grain size	according to ISO 14174: 2-20 (0,2-2,0 mm.)		
Density	about 1,08 kg./dm³		
Rebaking	at 350 °C for 2 hours to obtain diffusible hydrogen bellow 5 ml/100 gr.		
Packaging	in plastic bags of 25 kg. each		

Chemical composition of all weld metal (typical values %)

In combination with wire	C%	Mn%	Si%	Cu%	Ni%	Cr%	Mo%
PITTARC S1	0,04	1,0	0,3	–	–	–	–
PITTARC S2	0,05	1,4	0,3	–	–	–	–
PITTARC S2Si	0,05	1,4	0,5	–	–	–	–
PITTARC S3Si	0,06	2,0	0,5	–	–	–	–
PITTARC S2Mo	0,06	1,4	0,5	–	–	–	0,5
PITTARC S3Mo	0,06	1,6	0,4	–	–	–	0,5
PITTARC SH2	0,07	1,3	0,5	0,5	0,7	0,3	
PITTARC S3Ni1Mo0,2	0,07	1,5	0,5	–	0,9	–	0,2

Mechanical properties of all weld metal (single values are typical values)

In combination with wire type	Heat treat.	Yield Strength [N/mm ²]	Tensile Str. [N/mm ²]	Elong. [%]	Impact Values - ISO-V [Joule]			
					-20 °C	- 30 °C	- 40 °C	- 51 °C
PITTARC S1	AW	360	465	30	95	75	65	–
PITTARC S2	AW	410	510	29	80	–	55	–
PITTARC S2Si	AW	425	520	29	100	–	60	40
PITTARC S3Si	AW	480	580	28	95	–	65	40
PITTARC S2Mo	AW	500	580	27	80	70	50	–
PITTARC S3Mo	AW	535	620	27	70	60	45	–
PITTARC SH2	AW	490	580	27	70	50	–	–
PITTARC S3Ni1Mo0,2	AW	560	630	25	85	70	60	40

Heat treatment: AW = as welded

The above mentioned data may change without prior notice.

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