

## INCOFLUX<sup>®</sup> 4 Submerged Arc Flux

**INCOFLUX 4** is an agglomerated Submerged Arc Welding (SAW) Flux designed for wire welding with INCONEL Filler Metal 82. Typical applications are groove welding INCONEL alloys 600 and 601, INCOLOY alloy 800, to themselves and to other materials. The flux and wire combination is preferred when joining carbon steels to stainless steels because it provides optimum coefficient of thermal expansion properties. One major application is for overlaying carbon steels with the corrosion and oxidation resistant INCONEL Filler Metal 82.

**Welding Parameters:** Groove and Overlay Welding using DCEP current and Stringer beads.

Diameter	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Burden
0.062 in. 1.6 mm	240-290	30-33	8-11 in./min. 200-280 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	250-300	30-33	8-11 in./min. 200-280 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

**Overlay Welding with Oscillation:** Use DCEN current and Oscillation Frequency of 50-70 cycles/min for 0.062 in. and 35-60 for 0.093 in.

0.062 in. 1.6 mm	240-260	32-34	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 in. 19-25 mm
0.093 in. 2.4 mm	300-400	34-37	4 in./min. 100 mm/min.	7/8-1 in. 22-25 mm	3/4-1 1/4 in. 19-32 mm

**Specification**  
 EN 760 - S A FB2

**Particle Size**  
 Tyler Sieves: 10 x 60 Mesh (0.25 mm x 2.0 mm), EN 760 2-20

**Packaging**  
 60 pound (27.22 kg) Polyethylene Bucket with a hermetically sealed lid that has a rubber gasket seal.

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