

INCOFLUX[®] 8 Submerged Arc Flux

INCOFLUX 8 is an agglomerated Submerged Arc Welding (SAW) Flux designed for wire welding primarily with MONEL Filler Metal 67, although it can also be used with MONEL Filler Metal 60. Typical applications are groove welding 70/30, 80/20, and 90/10 Copper-Nickel alloys. It can also be used for overlaying carbon steels, but requires a buffer layer of either Nickel Filler Metal 61 or MONEL Filler Metal 60 in order to prevent excess iron dilution that can embrittle the copper-nickel deposit.

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

Diameter	Amperes	Volts	Travel Speed	Extension Stick-Out	Flux Depth
0.062 in. 1.6 mm	260-280	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	300-350	32-35	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	260-280	32-35	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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