



## INCOFLUX<sup>®</sup> NT110 Submerged Arc Welding Flux

**INCOFLUX NT110** is an agglomerated Submerged Arc Welding (SAW) Flux for wire welding with MONEL Filler Metal 60 (70% Ni, 30% Cu) and MONEL Filler Metal 67 (70% Cu, 30% Ni). Typical applications with MONEL Filler Metal 60 are groove welding MONEL alloy 400 to itself and to ferritic materials. A major application is for overlaying carbon steels with the corrosion resistant MONEL Filler Metal 60.

The flux is used with MONEL Filler Metal 67 to join Copper-Nickel alloys (90/10, 80/20 and 70/30). Overlays on ferritic steels require a buffer layer of Nickel 61 or MONEL 60.

**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 1/2 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 35-50 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	1/2-1 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.