

IABCO 1995

Sub-arc flux

Product name	IABCO 1995					
Classification EN ISO	14174: SA AB 1 67 AC H5					
Classification AWS	A5.23: With IABCO S2Si wire F7A4-EM12K / F6TA2-EM12K					
Flux composition	CaO+MgO: 20%		CaF ₂ : 15%			
	Al ₂ O ₃ +MnO: 40%		SiO ₂ +TiO ₂ : 20%			
Boniszewski index	1.3					
Grain size, EN760	2-20					
Applications	<p>IABCO 1995 is a neutral agglomerated flux for longitudinal multi-arc welding in pipemills. The flux has excellent welding characteristics and bead profile. The flux is also capable of low diffusible hydrogen, and low nitrogen for good impact properties.</p> <p>Suitable for single pass welding with up to five arcs, for high speed longitudinal welding of line pipe.</p>					
Base materials	For pipemill applications on pipe from API 5L: X52 (ISO 3183: L360) up to X80 (L555).					
Typical analysis of weld deposit, wt %		Procedure	C	Si	Mn	
	S2Si wire	All-weld	0.06	0.3	1.4	
	S2Si wire	2 Run	0.12	0.2	0.9	
Typical heat treatment ⁽¹⁾	Welding procedure (including preheat temperature, interpass temperature and PWHT) will be dependent on the base material being welded, including its thickness, and any applicable design codes.					
Mechanical properties of weld deposit ⁽²⁾		Procedure	Rp0.2% MPa	Rm MPa	A4 %	CVN, J
	S2Si wire	All-weld	430	540	29	80 (-40°C)
	S2Si wire	2 Run	400	550	30	40 (-29°C)
Redry of flux	250-450°C for 2-4 hours.					

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.