

INCOFLUX[®] NT120 Submerged Arc Welding Flux

INCOFLUX NT120 is an agglomerated Submerged Arc Welding (SAW) Flux for wire welding with the corrosion resistant nickel-chromium-molybdenum-tungsten alloys such as INCONEL Filler Metal 622, INCO-WELD C-276 Filler Metal, and INCO-WELD 686CPT Filler Metal. Typical applications are the groove welding of nickel alloys of a similar composition (eg. C-22, C-276, 59, 686). The flux and wire combinations are also for welding stainless steels (eg. 6% Mo and duplex stainless steels, etc.) and nickel alloys where enhanced weld metal corrosion properties are required through the Ni-Cr-Mo-W filler metals.

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	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 35-50 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 AF2

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.