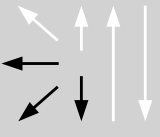


Classification																	
EN ISO 14174																	
SA FB 2 AC																	
Characteristics and typical fields of application																	
Marathon 444 is a highly basic agglomerated welding flux, designed for welding and cladding of NiCr(Mo) alloys. Highly resistant against hot cracking thanks to its low level of Si pick up.																	
Base materials																	
Nickel and nickel alloys																	
Composition of sub-arc welding flux (wt. %)																	
	SiO ₂ +TiO ₂			Al ₂ O ₃ +MnO			CaO+MgO			CaF ₂							
wt-%	7			30			40			20							
Operating data																	
		Polarity		Basicity acc. to Boniszewski:				4.5 (mol%) ; 2.9 (wt%)									
		DC (+) / DC (-)		Bulk density:				1.0 kg / dm ³									
		AC		Grain size acc. to EN ISO 14174:				3 – 16 (0.3 – 1.6 mm)									
				Flux consumption:				1.0 kg flux per kg wire									
				Redrying:				300 – 350 °C, 2 hrs min.									
Typical Composition of all-weld Metal with different Wires																	
SAW wires	C	Si	Mn	Cr	Mo	Ni	Nb	Ti		Co	Fe						
Thermanit Nicro 82	0.02	0.25	3.0	20.0		Rem.	2.4				< 1.0						
Thermanit 625	0.02	0.25	0.2	21.5	8.5	Rem.	3.2				< 1.0						
Thermanit Nimo C 24	0.015	0.20	< 0.5	22.5	15.8	Rem.					< 1.0						
Thermanit 617	< 0.06	< 0.40	< 0.30	21.2	8.9	Rem.			Al 1.1	10.0	< 1.0						
Thermanit NiMo C 276	< 0.012	0.15	0.5	15.5	16.0	Rem.			W 3.3		< 7.0						
Wire classification																	
EN ISO 18274						AWS A5.14											
Thermanit Nicro 82						S Ni 6082 (NiCr20Mn3Nb)						ERNiCr-3					
Thermanit 625						S Ni 6625 (NiCr22Mo9Nb)						ERNiCrMo-3					
Thermanit Nimo C 24						S Ni 6059 (NiCr23Mo16)						ERNiCrMo-13					
Thermanit 617						S Ni 6617 (NiCr22Co12Mo9)						ERNiCrCoMo-1					
Thermanit NiMo C 276						S Ni 6276 (NiCr15Mo16Fe6W4)						ERNiCrMo-4					