

SAW-flux, nickel-base

Brand Standard AWS Standard EN ISO	Main constituent: %			Grain size / density	Characteristics and Applications
MARATHON 104 EN ISO 14174: S A FB 2 AC	CaF ₂ 23	SiO ₂ 14	CaF ₂ +CaO+MgO+MnO 65	Grain size acc. EN ISO 14174: 3 – 20 (0.3 – 2.0 mm)	Marathon 104 is an agglomerated fluoride-basic flux for submerged arc welding of stainless / heat resistant steel grades and Ni-base alloys. This flux is – above all – recommended for highest demands on crack resistance and the mechanical properties of the weld metal, especially with heavy wall thickness. Combined with stainless wire grades it provides a high degree of purity in the weld metal, with good mechanical properties and good corrosion resistance. The flux does not compensate chromium loss. Its metallurgical behavior in regard of carbon, silicon and manganese is neutral. Good slag detachability and nice bead appearance. The weld metal is characterized by good mechanical properties and high resistance to hot cracking and is recommended for the highest demanding applications, e.g. creep resistant (Thermanit ATS), non-magnetic and cryogenic applications (especially recommended for LNG applications with Thermanit Nimo C 276).
MARATHON 444 EN ISO 14174: SA FB 2 AC	SiO ₂ 7	CaO+MgO+CaF ₂ +MnO 61	CaF ₂ 19	Grain size acc. EN ISO 14174: 3-16 (0.3-1.6mm)	Marathon 444 is a highly basic agglomerated welding flux, designed for welding and cladding of nickel-base-alloys. The weld metals show excellent mechanical properties with high hot cracking resistance.

Finishing chemicals

Product Name	Product type	Characteristics and Applications
BlueOne™ Pickling Paste 130	Paste	A unique world patented safer to use pickling paste. This low fuming pickling paste reduces toxic nitric fumes by 80%. Suitable for pickling of standard stainless steel grades such as 304 and 316.
RedOne™ Pickling Spray 240	Spray	A unique, safer to use pickling spray. This low fuming pickling spray reduces toxic nitric fumes by 50%. Suitable for pickling of standard stainless steel grades such as 304 and 316.
FinishOne Passivator 630	Spray	An acid free passivator, which creates no hazardous waste. The passivator can be used after mechanical cleaning of stainless steel surfaces to remove remaining grinding dust and iron particles. It can also be used after pickling to accelerate the rebuilding of the protective layer of chromium oxide.
Cleaner 401	Spray	A heavy duty stainless steel cleaner. Suitable for pre cleaning and degreasing of stainless steel surfaces before pickling. Could also be used for maintenance cleaning to restore and brighten stainless steel surfaces and remove surface rust. The Cleaner 401 can be used for maintenance cleaning and surface restoration together with Passivator 630 to further improve the cleaning effect.