



SAQ
SIAT

**TECHNICAL SPECIFICATION
SUBARC FLUX
PITTARC FL188F**

Document
Revision
Date
Page

SPP403
04 i
18.09.2014
1/2

1. DESCRIPTION

Agglomerated semi-basic welding flux suitable for carbon alloy steel welding in single and multipass technique and in single or multi-wire application.

Flux standard: ISO 14174 – S A AB 1 67 AC H5

2. PRODUCT CHEMICAL COMPOSITION (%)

	SiO ₂	TiO ₂	Al ₂ O ₃	MgO	CaF ₂	CaO	MnO
min	18	-	27	19	15.5	-	5
max	23	2.5	31	23	19.5	2	8

3. PHYSICAL PROPERTIES

H diffusible (ml/100g) : max 5ml/100g

Basicity Index : ≈ 1.3

Grain size : 2 – 16 (ISO 14174)

4. PACKING.

Bags containing 25 kg net on pallets of 1000 kg.

5. IDENTIFICATION.

Flux standard ISO 14174 – S A AB 1 67 AC H5

Each bag is labelled with the name **PITTARC FL 188 F**, batch number, net weight, name and address of S.I.A.T., grain size (2 – 16), rebaking between 350°C/2h.

Standards according AWS:

AWS A5.17: F7A4-EM12K (S2) / F7P4-EM12K (S2)

AWS A5.23: F8A2-EA2-A2 (S2Mo) / F8P2-EA2-A2 (S2Mo)



SIAT SpA via Facini, 54 - 33013 Gemona del Friuli (UD) ITALY
phone +39 0432 062 911 - fax +39 0432 062 903 - www.pittini.it - siat@pittini.it

FL 188 F

Welding flux ISO 14174 - S A AB 1 67 AC H5

Classification of combinations:

AWS A5.17 : F7A4-EM12K (S2) / F7P4-EM12K (S2)

AWS A5.23 : F8A2-EA2-A2 (S2Mo) / F8P2-EA2-A2 (S2Mo)

Particle size range: 2 - 16 (ISO 14174)

Redrying at 350° C/ 2h



Rev.0

Lotto: XXXXX

KG XXXX

SIAT – Società Italiana
Acciai Trafilati S.p.A.
Via Facini, 54
33013 Gemona del Friuli (Ud)
Tel.: +39 0432 062911
Fax: +39 0432
www.pittini.it



SAQ
SIAT

**TECHNICAL SPECIFICATION
SUBARC FLUX
PITTARC FL188F**

Document
Revision
Date
Page

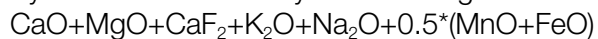
SPP403
04 i
18.09.2014
2/2

6. CERTIFICATION.

Certificate according EN 10204 2.2 annex to the delivery documents.

7. NOTE :

Basicity index determined by the following formula:



$$\text{IB} = \frac{\text{CaO} + \text{MgO} + \text{CaF}_2 + \text{K}_2\text{O} + \text{Na}_2\text{O} + 0.5 * (\text{MnO} + \text{FeO})}{\text{SiO}_2 + 0.5 * (\text{Al}_2\text{O}_3 + \text{TiO}_2 + \text{ZrO}_2)}$$