



SAQ
SIAT

**TECHNICAL SPECIFICATION
SUBARC FLUX
PITTARC FL193B**

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1. DESCRIPTION

Agglomerated semi-basic welding flux suitable for high quality steel pipes for gas and oil. Especially suitable for single and multi-wire (up to 5 wires).

Flux standard: ISO 14174 – S A AB 1 66 AC H5

2. PRODUCT CHEMICAL COMPOSITION (%)

	SiO ₂	TiO ₂	Al ₂ O ₃	MgO	CaF ₂	CaO	MnO
min	18	1.5	23	17	18	1	6.5
max	22	2.5	27	20	21	2	8

3. PHYSICAL PROPERTIES

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

Basicity Index : ≈ 1.4

Grain size : 2 – 20 (ISO 14174)

4. PACKING.

Plastic bags containing 25 kg net on pallets of 1000 kg.

5. IDENTIFICATION.

Each bag is labelled with the name **PITTARC FL 193B**, batch number, net weight, name and address of S.I.A.T., grain size (2 – 20), rebaking between 150 and 250°C
Flux standard ISO 14174 – S A AB 1 66 AC H5

Standards according AWS:

AWS A5.17: F7A4-EM12K (S2) / F7A5-EH12K (S2Si)

AWS A5.23: F8A4-EA2-A2 (S2Mo) / F8A4-EA4-A4 (S3Mo)
F9A2-EA3-A3 (S4Mo) / F9A4-EF3-F3 (S3Ni1Mo)



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FL 193 B

Welding flux ISO 14174 – S A AB 1 66 AC H5

Classification of combinations:

AWS A5.17: F7A4-EM12K (S2) / F7A5-EH12K (S3Si)

AWS A5.23: F8A4-EA2-A2 (S2Mo) / F8A4-EA4-A4 (S3Mo)

F9A2-EA3-A3 (S4Mo) / F9A4-EF3-F3 (S3Ni1Mo)

Particle size range: 2 – 16 (ISO 14174)

Redrying at 150-250°C

**LOTTO N°
KG 25**

WARNING: Welding fumes and gases are hazardous to your health and may damage lungs and other organs. Use adequate ventilation! Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection. Electric shock can kill. Read and understand the Safety Data Sheet for this product.

ATTENZIONE: Fumi e gas di saldatura sono pericolosi per la salute e possono danneggiare i polmoni ed altri organi. Usare adeguata ventilazione! L'arco elettrico e gli spruzzi possono danneggiare gli occhi e la pelle. Indossare adeguate protezioni per la testa, gli occhi ed il corpo. Lo shock elettrico può uccidere. Leggere e comprendere la Scheda di Sicurezza di questo prodotto.

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6. CERTIFICATION.

Certificate according EN 10204 2.2 annex to the delivery documents.

7. NOTE :

Basicity index determined by the following formula:

$$IB = \frac{CaO + MgO + CaF_2 + K_2O + Na_2O + 0.5 * (MnO + FeO)}{SiO_2 + 0.5 * (Al_2O_3 + TiO_2 + ZrO_2)}$$