








Список сравнения SAW Fluxes

Company	Products	Classification EN 760	Basicity	Nearest Application equivalence	Additional comments
	AS 231(M)	S A AR 1 78 AC H5	0,75	780/781/782	
	AS 450	S A AB 1 76 AC H5 2-16	1,1	860 / P 230	
	AS 450 (LPG)	S A AB 1 76 AC H5 2-12	1,1	860	
	AS 461	S A AB 1 78 AC H5 2-16	1,45	P230/761*/995N*	* on one side applications
	AS 462	S A AB 1 66 AC H5 2-16	1,33	860/P230	
	AS 589	S A FB 1 55 AC H5	2,9	888/P240/8500	
	CN 100	S A AB 2 DC	2,7	P2000	
	LEXAL F 500	S A AB 2 DC	2,7	P2000	
	AS 516	S A AB 2 AC H5	1,3	P7000/P2000	
	FREEZAL F Ni3	S A FB 1 55 AC H5	3,1	P2000	
	AS 530	S A FB 2 Ni4 G3 AC H10	2,7	P7000	
	CY 76	S A AR 1 88 AC H5	0,7	780	
		CY 95	S A AB 1 66 AC H15	1,06	960
CY 60		S A AB 1 77 AC H5	1,31	860	860 basicity and activity lower than CY 60's
CY10		S A AB 1 77 AC H5	1,31	860	860 basicity and activity lower than CY 10's
CY15		S F MS 1 77 AC H10	0,7		
CY 20		S A FB 1 76 AC H10	2,46	P230/888/8500/P240	888 is less active
CY70		S A Z 1 98 AC H10	1,4	782??	
CY81		S A Z 1 98 AC H10	0,94	781	781 is more acid (0,6)
CY 25		S F MS 1 66 AC H15	0,88		
CY 28		S A FB 1 66 AC H5	1,8	P230	Better mechanical properties with P230
CY 542		S A AB 1 88 AC H10	0,8	780/781??	
CY 100		S A Z 2 9 AC H10	3,2	P2000	
CY 150		S A AB 2 65 AC	2,7		
		OP 119	S A CS 1 77 AC	1	761
	OP 143	S A CS 1 98 AC	1	761	
	OP 181	S A AR 1 88 AC	0,4	780	
	OP 185	S A AR 1 88 AC	0,5	780	
	UNIFlux D1	S A AR 1 97 AC	0,4	781/782	
	OP 123	S A AB 1 67 AC	1	960	
	OP 100	S A AB 1 76 AC	0,8	960	
	OP 180 S		1,2	960/860	
	OP107	S A AB 76 AC	1	860	
	OP192	S A AB 1 67 AC	1,3	P223	
	OP 37 STC	S A FB 1 55 AC H5	2,6	888	
	OP132			998N	
	OP 139	S A AB 1 67 AC			
	OP150	S F MS 1 78 AC	0,7		
	OP 155	S A MS 1 89 AC	0,8	781	
	OP 160	S A AB 1 88 AC			
	OP 41 TT	S A FB 1 53 DC H5	3,1	P240	
	OP 42 TT	S A FB 1 66 AC H10	3,1	P240	
	OP 120TT	S A FB 1 66 AC	3,1	888	
	OP 121TT	S A FB 1 55 AC H5	3,1	888	
	OP 122	S A FB 1 65 AC H5	1,7	P230	
	OP 121 TT-W	S A FB 1 55 AC H5		888	
	OP 125 W	S A FB 1 55 AC H5	2,6	888	
	ALCROMO F 537	S A FB 1 55 AC H5	2,6	888	
	OP 33	S A AF 2 54 DC	1,8	P2000	
	OP 76	S A FB 2 55 AC H5	2,7	P2000	
	OP X Ni 9	S A AB 2 AC H5		P7000	
	OPF SR	S A FB 1 43 AC H5	2,1		
	OP87	S A CS 2 99 Cr AC	1	//////////	
	OP70Cr	S A FB 2 74Cr DC	1,2	P2000S	
OP74Cr	S A FB 2 55Cr AC	2,4	P2000S		
OP79	S A FB 2 57 AC H5	2,7	P2000		
				High alloyed steels	

Company	Products	Classification EN 760	Basicity	Nearest Application equivalence	Additional comments
	OK Flux 10.05	S A Z 2 DC		P2000	
	OK Flux 10.07	S A CS 2 NiMo DC			
	OK Flux 10.16	S A AF 2 DC	2,4	P 7000	
	OK Flux 10.30	S A Z 1 65 AC	1,8	761/995N	one side
	OK Flux 10.37	SA FB 2 DC	1,7	802	
	OK Flux 10.40	S F MS 1 88 AC	0,7		
	OK Flux 10.42	S F CS 1	0,8		
	OK Flux 10.45	S F MS 1 55 AC	0,85		
	OK Flux 10.47	S F AB 1 65 AC H5	1,3		
	OK Flux 10.49	S F AB 1 65 AC	1,2		
	OK Flux 10.50	S F	2	//////////	Electroslag welding
	OK Flux 10.61	S A FB 1 65 DC	2,8	P240/888	
	OK Flux 10.62	S A FB 1 55 AC H5	3,4	P 240/888	
	OK Flux 10.63	SA FB 1 55 AC H5	3,2	P240/888	
	OK Flux 10.69	?	1,5	761/995N	backing Flux
	OK Flux 10.70	S A AB 1 79 AC	1,7		
	OK Flux 10.71	S A AB 1 67 AC H5	1,6	P 230	P230 is less basic
	OK Flux 10.72	S A AB 1 57 AC	1,9	P230	
	OK Flux 10.73	S A AB 1 66 AC H5	1,3	P223	
	OK Flux 10.74	S A AB 1 67 AC H5	1,4	P223	
	OK Flux 10.75	S A FB 1 54 DC H5	1,9	888	
	OK Flux 10.80	S A CS 1 89 AC	1,1	761	
	OK Flux 10.81	S A AR 1 97 AC	0,6	781	
	OK Flux 10.82	SA AR 1 86 AC	0,6	780	
	OK Flux 10.83	S A AR 1 85 AC	0,3	781/782	
	OK Flux 10.92	S A CS 2 Cr DC	1		norme DIN : BCS5 71645 DC 8 MB 2-16
	OK Flux 10.93	SA AF 2 DC	1,7//1	P 2000	
	OK Flux 10.94	SA AF 2 Cr DC	1,7	P 2000S	
OK Flux 10.96	S A CS 3 Cr DC	0,7-0,9		hardness up to 40 HRC	
	BB 24	S A FB 1 65 DC H5			
	BB 25	S A FB 1 68 AC H5	2,8		
	BB 33M	S A AR 1 97 AC	0,4	780/781	
	BB 202	S A FB 2 DC	2,3	P2000	
	BB 203	S A FB 2 DC	2,7		
	BB400	S A AB AC			
	BB 430	S A FB 1 55 AC	2,9	P 240	
	BB431	S A FB 2 64 DC	2,3		
	BB 444	S A FB 2 AC		P7000	
	BB 910	S A FB 2 55 DC H5			
	UA 600	S A AB 1 65 DC H5			Non alloyed steels
	UV 300	S A MS 1 87 AC H5			
	UV 305	S A AR 1 76 AC H5			
	UV 306	S A AR 1 77 AC H5		780	
	UV 309 P	S A AB 1 65 AC H5			
	UV 310 D	S A FB 1 55 DC H5			
	UV 400	S A AB 1 67 AC H5			
	Marathon 543	S A FB 2 55 DC			
	UV 420			P230	Creep resistance and cryogenic steels
	UV 420 TT/ UV 420 TT-LH	S A FB 1 65 DC H5		888	
	UV 420 TTR/ UV 420 TT-W	S A FB 1 65 DC H5		888	
	UV 420 TTRC	S A FB 1 65 DC			
	UV 430 TTR-W	S A FB 1 55 AC			
UV 418 TT	S A FB 1 55 AC H5			Fine grains steels	
UV 421 TT	S A FB 1 65 DC H5		888		
	BF1	S A AR 1 76 AC	0,6	780	
	BF3	S A ZS 1 79 AC	0,8	780/781	
	BF4	S A AB 1 76 AC H5	1,1	860	
	BF6.5	S A FB 1 67 AC H5	1,7	888	
	BF16				
	BF25	S A AF 2 DC	1,2	P2000	
	BF40	S A CS 2 AC	1		
	WP 330-X	S F FB 1 54 DC H5	3,1		
WP 380	S F CS 2 DC H5	1,3			



Non and low alloyed flux				
FX 761	OK Flux 10.80	OK Flux 10.69	OK Flux 10.30	
FX 780	OK Flux 10.82			
FX 781	OK Flux 10.81	OK Flux 10.83		
FX 782	OK Flux 10.83			
FX 860				
FX 960				
FX 980				
FX 995N	OK Flux 10.69	OK Flux 10.30		
FX 998N				
P223	OK Flux 10.73	OK Flux 10.74		
P230	OK Flux 10.71	OK Flux 10.72		
FX 8500	OK Flux 10.61	OK Flux 10.62	OK Flux 10.63	
FX 888	OK Flux 10.61	OK Flux 10.62	OK Flux 10.63	
P240	OK Flux 10.61	OK Flux 10.62	OK Flux 10.63	
High alloyed flux				
P2000	OK Flux 10.05	OK Flux 10.93		
P2000S	OK Flux 10.94			
P7000	OK Flux 10.16			
Hardfacing				
FX 802	OK Flux 10.37			



Non and low alloyed flux				
FX 761				
FX 780	UV 306			BB 33M
FX 781				BB 33M
FX 782				
FX 860				
FX 960				
FX 980				
FX 995N				
FX 998N				
P223				
P230	UV 420			
FX 8500				
FX 888	UV 421 TT	420 TTR/ UV 420 TT	UV 420 TT-LH	
P240				BB 430
High alloyed flux				
P2000				BB 202
P2000S				
P7000				BB 444
Hardfacing				
FX 802				



Non and low alloyed flux					
FX 761					
FX 780	AS 231(M)			BF1	BF3
FX 781	AS 231(M)				BF3
FX 782	AS 231(M)				
FX 860	AS 450	AS 450 (LPG)	AS 462		BF4
FX 960					
FX 980					
FX 995N					
FX 998N					
P223					
P230	AS 450	AS 462			
FX 8500	AS 589				
FX 888	AS 589				BF6.5
P240	AS 589				
High alloyed flux					
P2000	CN 100	LEXAL F 500	FREEZAL F Ni3		BF25
P2000S					
P7000	AS 530	AS 516			
Hardfacing					
FX 802					



Non and low alloyed flux						
FX 761			OP 119	OP 143		
FX 780	CY 76	CY542	OP 181	OP 185		
FX 781	CY81	CY 542??	UNIFlux D1	OP 155		
FX 782	CY70??		UNIFlux D1			
FX 860	CY 60	CY 10	OP 180 S	OP107		
FX 960	CY 95		OP 123	OP 100	OP 180 S	
FX 980						
FX 995N			OP 132			
FX 998N						
P223			OP192			
P230	CY 28	CY 20	OP 122			
FX 8500	CY 20					
FX 888	CY 20		OP 37 STC	OP 120TT	OP 121TT	OP 121 TT-W
FX 888			OP 125 W	ALCROMO F 537		
P240	CY 20		OP 41 TT	OP 42 TT		
High alloyed flux						
P2000	CY 100		OP 33	OP 76	OP79	
P2000S			OP70Cr	OP74Cr		
P7000			OP X Ni 9			
Hardfacing						
FX 802						