

## SAW-flux, nickel-base

Brand Standard AWS Standard EN ISO	Main constituent: %				Grain size / density	Characteristics and Applications
<b>MARATHON 104</b>  EN ISO 14174: SA FB 2	SiO <sub>2</sub> +TiO <sub>2</sub> 15	CaO+MgO 36	Al <sub>2</sub> O <sub>3</sub> +MnO 20	CaF <sub>2</sub> 25	Grain size acc. EN ISO 14174: 1-20 (0.2-2.0 mm)	Marathon 104 is an agglomerated fluoride basic flux for submerged arc welding of stainless and heat resistant steel grades. Combined with stainless wire grades the flux has neutral metallurgical behaviour and it provides a high degree of purity in the weld metal, with good mechanical properties and good corrosion resistance. The flux does not have a Cr support. The weld metal is characterized by high resistance to hot cracking and is recommended for the highest demanding applications.
<b>MARATHON 444</b>  EN ISO 14174: SA FB 2 AC	SiO <sub>2</sub> +TiO <sub>2</sub> 7	CaO+MgO 40	Al <sub>2</sub> O <sub>3</sub> +MnO 30	CaF <sub>2</sub> 20	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 NiCr(Mo) alloys. Highly resistant against hot cracking thanks to its low level of Si pick up.

## Finishing chemicals

Product Name	Product type	Characteristics and Applications
<b>BlueOne™ Pickling Paste 130</b>	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.
<b>RedOne™ Pickling Spray 240</b>	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.
<b>FinishOne Passivator 630</b>	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.
<b>Cleaner 401</b>	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.