

AST 600 is a basic agglomerated submerged-arc welding flux used in combination with high nickel alloyed strip, such as Suprastrip 625.

The special formula enhances the weld bead profile with excellent and easy slag detachability. The weld bead shows a very high hot cracking resistance.

The flux is suitable for weld overlay in petrochemical, chemical and nuclear applications.

Damp flux should be re-dried at 300-350°C. Grain size according to EN 760: 2-20.

Wire	Classification
	DIN 32522 : B AB 7 8934 DC+ 15 B-2

Wire	Approvals	Grades

Flux Analysis	
CaF ₂	12 %
MnO	5 %
Al ₂ O ₃	39 %
CaO	19 %
MgO	7 %
SiO ₂	10 %

Basicity to Boniszewski 1,5

Analysis of all-weld metal (Typical values in %)

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	N	Fe
SUPRASTRIP 625 2nd Layer	0.03	1	0.24	20	Rem	9	3.10	-	4
SUPRASTRIP 625 3rd Layer	0.01	1	0.20	21	Rem	9	3.10	-	2

Packaging data

Metallic drum 30kg

Further forms of delivery on request.

Current condition

DC+