

# 802

## TOP FEATURES

- Neutral hardfacing flux
- Excellent slag removal even with high interpass temperature
- Compatible with a wide range of wire grade
- First recommended flux for any hardfacing subarc application

## CLASSIFICATION

Flux EN ISO 14174: S A CS 3 55 DC H5

## Flux/wire

Hardfacing solid and flux cored wire

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	Cr	Ni	Mo	V	W
LINCORE 102W	0.28	1.5	0.4	6.5		1.0	0.15	1.0
LINCORE 423L	0.15	1.2	0.4	11.5	2.0	1.0	0.15	
LINCORE 423Cr	0.15	1.2	0.4	13.5	2.0	1.0	0.15	

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Hardness: HRc in 6 layers hardfacing application after 2 hours postweld tempering at					
	AW*	426°C	482°C	538°C	593°C	649°C
LINCORE 102W	51	50	50	51	40	35
LINCORE 423L	43	42	46	38	33	32
LINCORE 423Cr	46	45	46	38	34	32

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
SRB BAG	25.0	FX802-25

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.