

Storage & Handling

Submerged Arc Flux and Wire

Re-Drying & Recycling Flux

Lincoln Electric submerged arc welding flux can be used directly from its original, undamaged package, if it has been stored according to the conditions listed in the chart below.

When proper procedures are not followed, flux may show signs of moisture. These can include porosity, a rough bead surface or slag that is unusually difficult to remove. In many instances these fluxes can be re-dried in general welding applications.

Re-Drying Flux

To re-dry fluxes other than MIL800-H & MIL800-HPNi

- Remove flux from its original packaging and place in a clean oven set between 260° - 480°C (500° - 900°F).
- Leave in oven long enough to raise the temperature of the entire bulk of flux to your set temperature for a minimum of one hour.
- For ovens in which heating rods are inserted into the flux, do not let the temperature of flux adjacent to the rods exceed 480°C (900°F).

For MIL800-H and MIL800-HPNi fluxes

Follow all previous procedures, with the following changes:

- Set temperature between 120° - 205°C (250° - 400°F).
- For ovens in which heating rods are inserted into the flux, do not let the temperature of flux adjacent to the rods exceed 205°C (400°F).

For all other fluxes requiring diffusible hydrogen control

Follow all previous procedures, with the following changes:

- Set temperature at approximately 425°C (800°F).

Recycling Flux

Non-consumed flux may be collected from the finished weld and recycled.

To do so, please follow these procedures:

- Remove slag, metal, mill scale, and any other contaminants from the flux.
- Prevent damage to the flux from heavy impingement in flux transport systems.
- Avoid the separation of different sized particles in cyclones or “dead” corners.
- Remove excess fines from recycled fluxes.
- For optimal welding characteristics, it is recommended to add at least 20% new flux by weight to recycled flux.

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Submerged Arc Flux / Wire and MIG Wire

STORAGE FOR SUBMERGED ARC FLUX

Flux Package Type ⁽¹⁾	Flux Storage Conditions for General Welding Applications	Flux Storage for Applications Requiring Diffusible Hydrogen Control
Plastic or Multi-Wall Plastic/Paper Bag	Store indoors at < 90% RH Protect from condensation	Store indoors at < 70% RH and 5°C - 50°C (40°F - 122°F). Protect from condensation
Bulk Bag with Liner	Store indoors at < 90% RH Protect from condensation	Store indoors at < 70% RH and 5°C - 50°C (40°F - 122°F). Protect from condensation
Steel Drum	Protect from rain or snow	Protect from rain or snow
Plastic Pail	Protect from rain or snow	Protect from rain or snow

STORAGE FOR MILD AND LOW ALLOY STEEL MIG AND SUBARC WIRES

Wire Package Type ⁽¹⁾	Wire Storage Conditions for All Welding Applications
Any Type	Protect from rain or snow. Protect from condensation. Do not use wire with visible signs of rust.

⁽¹⁾For other package types, consult your Technical Representative.