

**Kjellberg**<sup>®</sup>  
**FINSTERWALDE**

Cutting

Engineering

**SUBMERGED ARC WELDING**

**FLUX  
EQUIPMENT**



# **SUBMERGED ARC WELDING**

## **Flux Equipment**

Accessories for  
KA-Series, Retrofit & Applications

100  
YEARS  
KJELLBERG  
MADE IN GERMANY

[kjellberg.de](http://kjellberg.de)



Flux container 10 l with pressure and suction hose

## Flux Recovery well-proven & flexible

### Flux Feeding System

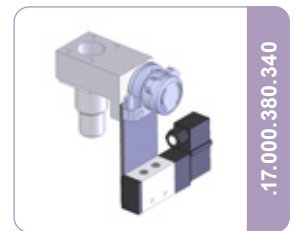
Kjellberg flux systems guarantee the constant flux feeding for the welding process. They are easy to use manually and are nearly maintenance-free. A sight glass shows the fill level in the reservoir.



**Flux system 6 l**  
with manual flux shutoff device,  
sieve and feed hose



**Flux system 10 l**  
with manual flux shutoff device,  
sieve and feed hose



Option:  
**Pneumatic flux shutoff device**  
Suitable for Kjellberg flux  
systems, especially suitable for  
columns and booms and welding  
gantries; control with supply  
voltage 24 V DC

### Flux Recovery System (Standard)

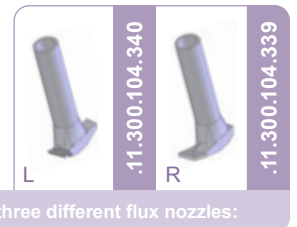
A flux circuit reduces the welding flux consumption. Such a flux recovery is suitable for SA welding tractors and welding heads.



**Flux recovery system** including  
injector, holder for the flux  
nozzle, 0.5 m suction hose and a  
flux nozzle for butt welds



• for butt welds (standard)



• for fillet welds (left or right)

The product range includes three different flux nozzles:

*Kjellberg flux systems for submerged arc welding are part of the Kjellberg welding automats.*

*They can be expanded by flux recovery units, pressure conveyor systems and fine dust filters. Existing welding systems can be retrofitted on request.*

**Fine Dust Filter**

A flux recovery unit with cyclone is available in order to extract the fine dust proportion from the flux circuit and thus to guarantee the flux transport and the high quality of the welding results. The separation is based on the injector principle.

This version is used in combination with external flux systems on welding heads and welding systems.



.17.000.406.380.1

**Fine dust filter** consisting of flux recovery unit, cyclone, baffle plate and cover, hose connection dia. 50 mm – option: dia. 63 mm



.16.007.116

**Filter box with manual de-dusting 35 l**  
Positioning away from the welding workplace, connection to the separator via suction hose of up to 8 m length (art. no. .10.575.0416)

**Flux Pressure Conveyor**

For the use in automated systems our product range offers flux pressure conveyors in two sizes which can be used in connection with a flux feeding system. They consist of the flux reservoir and the connected cyclone and run along with the gantry or column and boom.

All types are available as heated or unheated versions. The fill level is monitored via sensors.



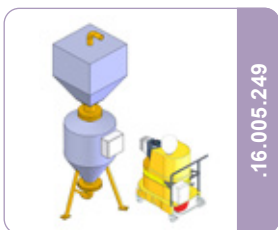
.16.004.698

**Flux pressure conveyor 50 l**  
plus pressure hose NW 25  
(.10.507.053)



.16.008.499

**Flux pressure conveyor 100 l**  
plus pressure hose NW 25  
(.10.507.053)



.16.005.249

**Flux pressure conveyor 50 l with separator 40 l and suction turbine**  
(.16.006.066, right on picture)

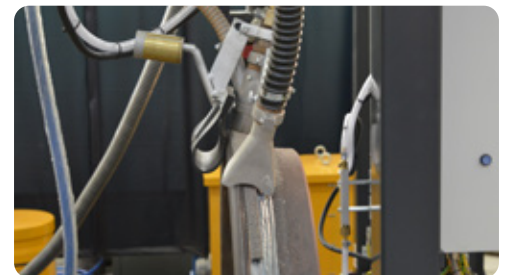


.16.008.051

**Flux pressure conveyor 100 l with separator 80 l and suction turbine**  
(.16.006.066, right on picture)



Flux pressure conveyor



Flux nozzle in use



Suction turbine



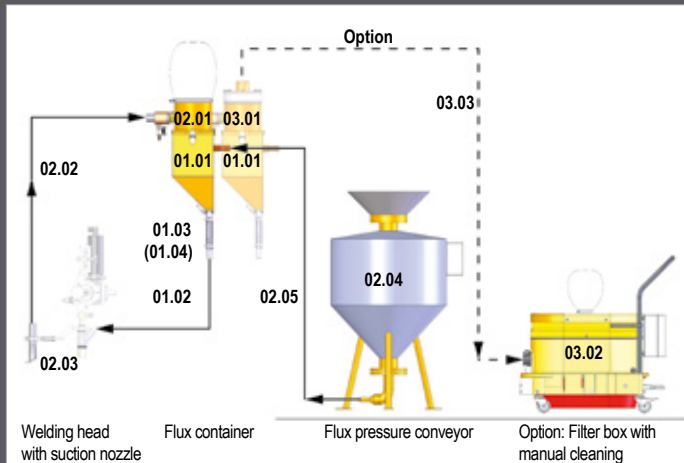
Display flux temperature



Pneumatic maintenance unit



Connection Variants: Accessories for basic flux cycle respectively cycle with pressure conveyor and filter box



#### Flux Cycle with Pressure Conveyor

02.01	Flux recovery KA	.11.300.100.360
02.02	Suction hose cyclon, NW 38, length 1.2 m	.11.200.100.345
02.03	Flux suction nozzle butt weld, standard	.10.575.075
	or Suction nozzle fillet weld right	.11.300.104.339
	or Suction nozzle fillet weld left	.11.300.104.340
02.04	Flux pressure conveyor 50 l, heated (120 °C)	.16.004.698
	or Flux pressure conveyor 100 l, heated (160 °C)	.16.008.499
02.05	Pressure hose NW 25	.10.507.053

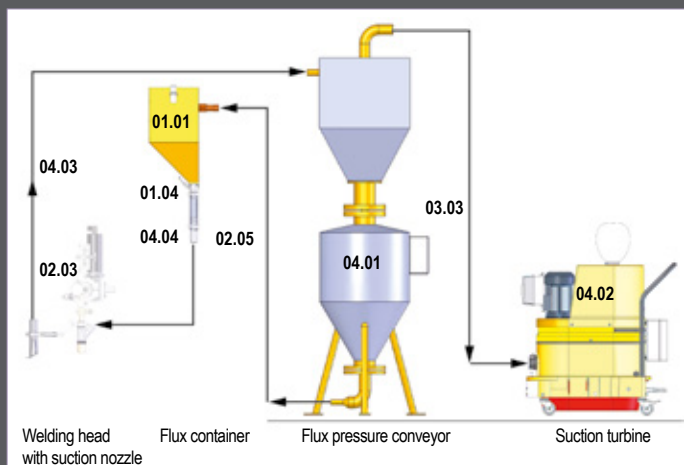
#### Standard Flux Supply

01.01	Flux container 10 l with filler neck dia. 25 mm	.11.300.105Y310.1
01.02	Flux supply hose NW 25, 0.55 m lang	.11.300.105.355
01.03	Manual flux valve	.11.300.100.340
01.04	Pneumatic flux valve	.17.000.380.340

#### Flux cycle with Pressure conveyor and Filter Box

03.01	Separator with hose connector dia. 50 (Standard)	.17.000.406.380.1
	option: top with hose connector dia. 63 mm	.17.000.406.380.3
03.02	Filter box with manual cleaning 35 l	.16.007.116
	or Filter box with pneumatic cleaning 35 l	.16.007.117
03.03	Suction hose separator	.10.575.0416

Connection Variants: Accessories for big flux cycle with pressure conveyor, separator and suction turbine



#### Flux cycle with Pressure Conveyor and Suction Turbine

04.01	Flux supply 50 l with separator 40 l heated (120 °C)	.16.005.249
	or Flux supply 100 l with separator 80 l heated (160 °C)	.16.008.051
04.02	Suction turbine with manual cleaning	.16.011.168
	or Suction turbine with pneumatic cleaning	.16.006.066
04.03	Suction hose NW 38	.10.575.0410
04.04	Flux supply hose NW 25	.10.507.052

## Kontakt

Kjellberg Finsterwalde Schweißtechnik und Verschleißschutzsysteme GmbH

An der Fimag 4 | 03238 Massen | Germany | ☎: +49 3531 500-800 | 📠: +49 3531 500-899

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