



MEMO

To: Whom It May Concern
From: Hobart Applications Engineering Department
Date: 8/5/2021
Re: Submerged Arc Flux Storage, Recycling, Reconditioning, and Disposal

The purpose of this memo is to provide manufacturer recommendations on the storage, recycling, reconditioning, and disposal of the Hobart Filler Metals portfolio of submerged arc welding fluxes. Always consult applicable contract and fabrication documents for additional requirements that may be imposed in your specific welding application.

Storage

Hobart welding fluxes in their original packaging can be safely stored for a maximum period of three years. Please note that Hobart Brothers products are warranted from defects in material and workmanship for a period of one year from the time of shipment in its original undamaged and unopened package. Make sure that the packaging cannot get damaged.

In case the original packaging gets damaged, flux shall be re-packed in sealed containers and stored under controlled climatic conditions of 15–35°C (60–95°F) and maximum 70 percent relative humidity, for a maximum period of one year.

At shift end, flux from unprotected flux hoppers and from opened packs shall be stored in a drying cabinet or heated flux hopper at 150°C ± 25°C (300°F ± 45°F).

Recycling

During continuous welding operations, unused flux can be recycled and returned to the flux hopper for reuse. Maintain compressed air in the recycling system, free from moisture and oil. Remove slag and mill scale from the recycled flux. Add at least one part of new flux to three parts of recycled flux after flux has been recirculated three times.

Reconditioning

For hydrogen critical applications, any flux suspected of having picked-up moisture must be re-dried at a temperature of 300–350°C (570–660°F) for a minimum of two hours. Re-drying time starts when the entire quantity of flux has reached 300°C (570°F). Re-dried flux must be stored at 150°C ± 25°C (300°F ± 45°F) before use.

Disposal

Hobart recommends that all fluxes be disposed of according to applicable local, state and federal regulations. Typically, fluxes are considered a “Special Waste” or “Industrial Solid Waste” by most disposal facilities. We recommend that end-users contact their local disposal facility to determine if a waste profile and laboratory analysis are required to determine the proper method of disposal. A local disposal facility can also advise on paperwork and tracking required for proper disposal.

For more information on flux storage, handling, and disposal, please contact Hobart Brothers via e-mail at Applications.Engineering@HobartBrothers.com.