

DESCRIPTION

- Highly basic agglomerated flux especially designed for high speed electroslag strip cladding.
- This flux is especially developed to reach the nominal chemical analysis of alloy 317L in 2 layers with Soudotape 21.13.3L.
- Excellent slag removal combined with enhanced wetting characteristics.
- If high speed conditions are not required, this flux is perfectly suitable for the standard cladding conditions.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.2 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 N° ASTM)
- Apparent density 0.9
- Consumption 0.55 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates (kg/h)	14	28	42

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Base metal 0.2 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1400 A – 24 V – 35 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
317L	-	21.13.3L	0.01	1.80	0.20	20.20	14.0	2.90	-	-	-
	1	21.13.3L	0.04	1.24	0.27	15.30	11.0	2.73	0.03	3.8	2.6
	2	21.13.3L	0.02	1.28	0.32	18.20	13.3	3.34	0.03	3.8	6.6
			1				0		7		

PACKING

25 kg (pail) : No SAP stock number created : internal data sheet : study still in progress.