Record EST 200

Flux for cladding

EN 760 : (E) SA FB 2

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of Alloy 200 (Pure Nickel) in 3 Layers with Soudotape NiTi.
- Excellent weldability and good wetting.
- Easy slag removal even at high temperatures.

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 0.8
- Consumption 0.75 (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)	11	22	33

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

- Base metal 0.2 % C - steel.
- Strip dimensions 60 x 0.5 mm.
- Cladding parameters Layer 1 :1650 A – 24 V – 20 cm/min.
  Layer 2 :1600 A – 24 V – 20 cm/min.
  Layer 3 :1420 A – 26 V – 18 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Ni	Ti	Fe	Thickn. (mm)
	-	NiTi	0.02	0.32	0.09	bal.	4.10	0.03	-
200	1	NiTi	0.042	0.51	0.96	bal.	1.70	17.90	5.5
	2	NiTi	0.025	0.42	1.11	bal.	2.26	5.12	5.5
	3	NiTi	0.024	0.40	1.28	bal.	2.28	1.47	5

PACKING

25 kg (pail) : SAP Stock number :42034.