Record EST 259

Flux for cladding

EN 760 : (E) SA FB 2

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of NiCrMo alloys like alloy 59 with Soudotape NiCrMo59 and alloy C-4 with Soudotape NiCrMo7.
- Recommended also for depositing a buffer layer prior of cladding Hastelloy C276.
- Excellent weldability and wetting action, easy slag release.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 3.8 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 N° ASTM)
- Apparent density 0.85
- Consumption 0.7 (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)	9	18	27

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

- Base metal 0.2 % C – steel.
- Strip dimensions 60 x 0.5 mm.
- Cladding parameters 900 A – 24 V – 18 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Fe	Thickn. (mm)
59	-	NiCrMo59	0.004	0.15	0.03	22.4	bal.	15.6	1.1	-
	1	NiCrMo59	0.027	0.33	0.50	19.9	bal.	13.1	14.3	3.8
	2	NiCrMo59	0.01	0.17	0.47	21.8	bal.	15.3	3.3	3.5
C-4	-	NiCrMo7	0.006	0.10	0.03	15.5	bal.	15.0	0.50	-
	1	NiCrMo7	0.027	0.30	0.40	13.3	bal.	14.2	12.6	3.5
	2	NiCrMo7	0.013	0.10	0.30	14.8	bal.	14.8	2.4	3.5
	3	NiCrMo7	0.010	0.10	0.30	15.0	bal.	15.2	1.7	3.5

PACKING

25 kg (pail) :SAP Stock number :42037.