

DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding with Soudotape 690.
- Especially developed to reach the chemical analysis of alloy 690 in 3 layers with Soudotape 690.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 2.6 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 1.0
- Consumption 0.8 (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)	8	15	22

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

- Base metal 0.2% C - steel.
- Strip dimensions 60 X 0.5 mm
- Cladding parameters 750 A – 29 V – 16 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Nb	Fe	Thickn. (mm)
690	-	690	0.015	2.60	0.17	30.40	bal.	1.70	10.10	-
	1	690	0.05	2.20	0.48	22.10	bal.	1.50	31.50	3.5
	2	690	0.038	2.45	0.48	26.10	bal.	1.70	20.20	3.5
	3	690	0.022	2.64	0.52	28.50	bal.	1.90	12.70	3.5

PACKING

25 kg (pail) : SAP Stock number :42014.