

DESCRIPTION

- Highly basic agglomerated flux designed for submerged arc strip cladding with strips Ni Cr (Mo-Fe).
- The low Si content of the weld metal assures a very low hot cracking sensitivity.

GENERAL CHARACTERISTICS

- Current DC +
- Basicity index 3.2 (according to Bonizewski; calculated in mole %).
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM).
- Apparent density 1.0
- Consumption 0.65 (kg fused flux / kg strip).
- Redrying 1 to 2 hours at 350 +/- 50°C.
- Applicable strip dimensions :

Strip widths (mm)	30
Typical deposition rates (kg/h)	15

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

- Base metal 0.18% C - steel
- Strip dimensions 30 x 0.5 mm
- Cladding parameters (1) 700 A – 28 V – 28 cm/min
(2) 600 A – 27 V – 21 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Ti	Thickn. (mm)
600	-	NiCr3	0.015	3.2	0.2	20.1	bal	-	2.6	1	0.3	-
	3	(1)	0.020	3.6	0.3	20.6	bal	-	2.5	2	0.15	4.5
625	-	625	0.02	0.1	0.15	22.0	bal	9.0	3.6	0.25	0.2	-
	2	(2)	0.02	0.9	0.20	21.6	bal	8.7	3.2	3.0	0.1	4.0
	3	(2)	0.02	1.0	0.20	21.9	bal	9.0	3.5	1.0	0.1	4.0

PACKING

25 kg (pail) : SAP stock number : 42009