Record NiCrT

Flux for cladding

EN 760 : SA AB 2
DIN 32522 : BAB7 7314DC+12B-3-16

DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding with Soudotape NiCr3 and 625.
- The low silicon content in the weld metal assures a very low hot cracking sensitivity.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.35 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 0.9
- Consumption 0.5 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60
Typical deposition rates(kg/h)	8	14

For widths over 60 mm, the electroslag strip cladding process is recommended.

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 - 24 V - 11 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Ti	Fe	Thickn. (mm)
600	-	NiCr3	0.015	3.2	0.2	20.1	bal.	-	2.6	0.3	1	-
	1	NiCr3	-	-	-	-	-	-	-	-	-	-
	2	NiCr3	0.03	2.7	0.6	18.7	bal.	-	2.4	0.05	3.8	4.7
	3	NiCr3	0.02	2.9	0.6	19.3	bal.	-	2.5	0.05	1.6	4.6
625	-	625	0.02	0.1	0.15	22.0	bal.	9.0	3.6	0.2	0.25	-
	1	625	-	-	-	-	-	-	-	-	-	-
	2	625	0.02	0.1	0.5	20.7	bal.	8.8	3.4	0.05	3.0	4.7
	3	625	0.02	0.1	0.5	21.0	bal.	8.8	3.5	0.05	1.0	4.6

PACKING

25 kg (pail) :SAP Stock number : 29090.
25 kg (bag) :SAP Stock number : 29091.