Record R 400 S

Flux for cladding

EN 760 : SA MS 3 C Cr Mo

DESCRIPTION

- C - Cr - Mo alloyed agglomerated flux for hardfacing with Soudor B.
- As deposited Hardness of around 40-45 HB with a good resistance to shocks and moderated resistance against abrasion.
- Reconstitution and hardfacing of pieces subjected to abrasion combined with heavy shocks: crane and mine car wheels, cylinders …
- Usable with both direct and alternating currents.

GENERAL CHARACTERISTICS

- Current — DC (+ and -) and AC – 900 A max.
- Basicity index — 0.65 (according to Bonizewski; calculated in mole %).
- Grain size — 0.4 – 1.4 mm (14 x 40 N° ASTM).
- Apparent density — 1.1
- Consumption — 1.1 (kg fused flux / kg wire).
- Redrying — 1 to 2 hours at 350 +/- 50°C.

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

Wire	EN 756	C	Mn	Si	Cr	Mo
Soudor B	S1	0.14	2.1	0.8	2.6	0.3

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	EN 756	Hardness	Structure
Soudor B	S1	42 HRc	Bainitic + martensitic

PACKING

25 kg (bag) : SAP stock number : 29171