Record RT 184

Flux for cladding

EN 760 : SA CS 3CrNiMo

DESCRIPTION

- Alloyed agglomerated flux for submerged arc strip hardfacing of rolls.
- Allows to deposit a 12 Cr – 4 Ni – 0.5 Mo – alloy and to reach 48HRc in 4 layers in combination with Soudotape 410L.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.95 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 1.1
- Consumption 0.8 (kg fused flux / kg strip)
- Redrying 1 to 2hours at 350 +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates (kg/h)	6.5	13	20

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

- Base metal 0.18 % C - steel
- Strip dimensions 60 x 0.5mm
- Cladding parameters 650A – 27V – 13 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickn. (mm)	Hardness HRc
	-	410L	0.01	0.30	0.36	12.7	0.12	-	-	-
	1	410L	5	0.70	0.76	2	2.30	0.46	4	45
			0.18			8.50				
	2	410L	0.18	0.58	0.87	10.0	3.00	0.63	4	46
	3	410L	0.18	0.59	0.89	0	3.35	0.70	4	46
	4	410L	0.18	0.63	0.89	10.5	3.45	0.70	4	49
						1				
						10.5				
						7				

PACKING

25 kg (bag) : SAP stock number :