Record RT 350

Flux for cladding

EN 760 : SA CS 3 Cr Mo
DIN 32522 : BAB3 65CCrMoDC+13B-3-16

DESCRIPTION

- C – Cr – Mo alloyed agglomerated flux designed for SAW strip cladding with Soudotape A or B.
- Depositing a 5 Cr - 0.8 Mo alloy with a 340 HB hardness after a treatment about 6 hours at 530°C.
- Suitable for cladding of continuous casting rolls.

GENERAL CHARACTERISTICS

- Current DC+.
- Basicity index 1.6 (according to Bonizewski; calculated in mole %).
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM).
- Apparent density 0.95
- Consumption 1 (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 ALL-WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Base metal 0.18% C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 900 A – 28 V – 13 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickn. (mm)	Hardness (HB)	
									As welded	PWHT*
5 Cr – 0.9 Mo	-	A	0.03	0.2	0.02	-	-	-	-	-
	2	A	0.07	0.25	0.25	4.6	0.80	3.8	325	350
	3	A	0.07	0.25	0.25	5	0.90	3.8	325	350
	-	B	0.07	0.45	0.04	-	-	-	-	-
	2	B	0.09	0.3	0.25	4.5	0.80	3.8	320	350
	3	B	0.09	0.3	0.25	4.6	0.85	3.8	325	350

* : Post weld heat treated for 6 hours at 530°C.

PACKING

25 kg (bag) : SAP stock number : 29179