

# **Record SMoTW**

Flux for cladding

EN 760 : SA CS 3 Mo

#### DESCRIPTION

- Agglomerated Mo alloyed flux (aluminate rutile type).
- Suitable for submerged arc strip cladding with Soudotape A.
- Service temperature up to 500°C.

## **GENERAL CHARACTERISTICS**

Current

•

- DC +
- Basicity index 1.1 ( according to Bonizewski; calculated in mole % )
  - Grain size 0.4 1.4 mm (14 x 40 N° ASTM )
- Apparent density 0.9
- Redrying 1 to 2 hours at 350 +/- 50°C

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

- Base metal 0.18% C steel
  - Strip dimensions 60 x 0.5 mm
- Cladding parameters 900A 26V 18cm/min

Alloy	Layer	Strip Soudotape	С	Mn	Si	Мо
0.5% Mo	-	A	0.026	0.19	0.01	0.01
	2	А	0.042	1.0	0.56	0.57

### TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL)

Strip	Rm	Rp0.2	A5d
	[MPa]	[MPa]	[%]
А	436	278	32

## PACKING

25 kg (pail) : SAP stock number : 29177