

EN 760 : SA AB 2
 DIN 32522 : BAB6 8215DC+10B-3-16

DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding.
- Suitable for strip cladding, depositing a fully austenitic alloy in 3 layers.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.1 (according to Bonizewski; calculated in mole %).
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 0.86
- Consumption 0.65 (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)	7	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 - 28 V - 12 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickness (mm)
25.22.2	-	310MM	0.015	4.50	0.15	25	22.30	2.10	-
	1	310MM	0.04	3.50	0.60	21	19.80	1.90	4.5
	2	310MM	0.035	3.60	0.60	23	21.30	2	4.1
	3	310MM	0.025	3.70	0.60	24.50	22.20	2.10	4.1

PACKING

25 kg (pail) : SAP Stock number : 29089.