

EN 760 : SA CS CrMo

DESCRIPTION

- Cr - Mo alloyed agglomerated flux for submerged arc cladding with strips & wires.
- In combination with Soudotape A or with wire Soudor B (EN 756 : S1), Record CrMo 15TW flux deposits a 1.3Cr -0.6Mo alloy in 2/3 layers.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.3 (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)
1.2 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates (kg/h)	7	15	20

- Applicable wire dimensions : 2.5 ; 3.2 ; 4.0 ; 5.0 mm

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

- Base metal 0.18% C - steel
- Strip type & dimensions SOUDOTAPE A : 60 x 0.5 mm
- Cladding parameters 800 A - 26V - 17 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickn. (mm)
1.5 Cr-0.5 Mo	-	A	0.030	0.19	0.01	-	-	-
	2	A	0.060	0.40	0.34	1.33	0.62	3.5
	3	A	0.036	0.45	0.32	1.28	0.61	3.5

- Base metal 0.18% C - steel
- Wire type & dimensions SK SOUDOR B (EN 756 :S1 / AWS A 5.17 : EL12) 4.0 mm
- Cladding parameters 500 A - 30V - 45 cm/min.

Alloy	Layer	Wire SK Soudor	C	Mn	Si	Cr	Mo	Hardness
1.5 Cr-0.5 Mo	-	B	0.054	0.42	0.14	-	-	-
	2	B	0.084	0.44	0.53	1.24	0.55	255 HB
	3	B	0.075	0.45	0.56	1.37	0.65	245 HB

PACKING

25 kg (pail) : SAP stock number : 36557.