

EN 760 : SA CS CrMo
DIN 32522 : BCS 3 75 CrMoDC+13 B 3-16

DESCRIPTION

- Cr - Mo alloyed agglomerated flux for submerged arc cladding with strips & wires.
- In combination with Soudotape A or B or with wire Soudor B (EN 756 : S1), Record CrMo 21TW flux deposits a 2.3Cr -1Mo 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 650 A - 28V - 13 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickn. (mm)	Hardness
2Cr-1Mo	-	A	0.026	0.19	0.01	-	-	-	-
	2	A	0.088	0.15	0.42	2.16	0.91	4	276HB
	3	A	0.101	0.13	0.44	2.33	1.00	4	276HB

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

Alloy	Layer	Wire Soudor	C	Mn	Si	Cr	Mo	Hardness
2Cr-1Mo	-	B	0.09	0.36	0.07	-	-	-
	2	B	0.134	0.35	0.72	2.72	1.38	39HRC
	3	B	0.139	0.33	0.83	3.35	1.65	38HRC

PACKING

25 kg (pail) : SAP stock number :