

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 25TW flux deposits a 2Cr -0.5Mo alloy in 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

TYPICAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Base metal 0.6% 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-0,5Mo	-	A	0.026	0.19	0.01	-	-	-	-
	1	A	0.14	0.59	0.43	1.41	0.47	4	240
	2	A	0.11	0.65	0.48	1.70	0.58	4	239
	3	A	0.08	0.56	0.48	1.92	0.62	4	238

PACKING

25 kg (pail) : SAP stock number : 57252