

## DESCRIPTION

- Agglomerated flux for submerged arc strip cladding with Soudotape CuNi30.
- In case of cladding on C-steel, a buffer layer with Soudotape NiCu7 and Record NiCuT is necessary.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM )
- Apparent density 0.75
- Consumption 0.70 (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)	10	20

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

- Base metal 0.18 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters (1) : 900 A - 26 V - 14 cm/min.  
(2) : 750 A - 28 V - 14 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cu	Ni	Fe	Ti	Thickn. (mm)
70Cu 30Ni	-	NiCu7+	0.02 5	3.2	0.1	29	bal.	0.15	2.3	-
	1	Record Ni CuT (1)	0.04	2.7	1.0	24	bal.	16.0	0.4	5
	-	CuNi30+	0.01	0.8	0.05	bal.	30	0.7	0.3	-
	2	Record CuNi30T (2)	0.03	1.0	0.40	bal.	38	5.0	0.25	4
	3		0.02	0.9	0.25	bal.	32	2.0	0.2	4

## PACKING

- 25 kg (pail) : SAP Stock number : 29096. (standard)  
25 kg (bag) : SAP Stock number : 29098. (on request)