

ISO 14174 : ES A FB 2
DIN 32522 : BFB6 63155DC+40B-2-12

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding.
- Excellent weldability, good wetting and easy slag release.
- The low dilution and elevated deposition rate make the use of this flux very interesting.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 4 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 Mesh ASTM)
- Apparent density 0.85
- Consumption 0.6 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Approvals TUV (with Soudotape 21.11LNb, 21.11 Nb, 22 11 LNb, 23.11 Nb,
20 25 5LCu and 21.13.3L)
- Applicable strip dimensions :

Strip widths (mm)	30	60	90	120	150	180
Typical deposition rates (kg/h)	10	21	33	40	45	50

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

- Base metal 0.2% C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters (1) 1250 A - 24 V - 16 cm/min. (3) 1250 A - 24 V - 17 cm/min.
(2) 1250 A - 24 V - 20 cm/min. (4) 1250 A - 24 V - 21 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	N	W	Thickn (mm)	Hardness or FN
308L	-	309L	0.015	1.80	0.30	23.40	12.80	-	-	-	-	-	-
	1	(4)	0.035	1.31	0.60	19.10	10.60	-	-	-	-	4.1	6 FN
	-	308L	0.015	1.70	0.30	19.80	10.10	-	-	-	-	-	-
	2	(1)	0.018	1.37	0.54	19.20	10.30	-	-	-	-	4.8	8 FN
316L	-	21.13.3L	0.01	1.8	0.2	20.5	13.5	2.9	-	-	-	-	-
	1	(1)	0.025	1.3	0.35	18.3	12.1	2.6	-	-	-	5	8 FN
	-	309L	0.015	1.80	0.30	23.40	12.80	-	-	0.056	-	-	-
	1	(2)	0.046	1.43	0.54	20.60	10.80	0.24	-	0.05	-	3.6	7 FN
	-	316L	0.012	1.70	0.26	18.60	12.70	2.69	-	0.055	-	-	-
2	(2)	0.021	1.45	0.60	18.80	12.20	2.40	-	0.046	-	3.6	7 FN	
347	-	21.11LNb	0.016	1.8	0.3	21.4	11.3	-	0.70	-	-	-	-
	1	(3)	0.030	1.4	0.4	19.0	10.1	-	0.50	-	-	4.8	7 FN
258 C-Cr-Mo	-	S258	0.29	1.65	0.45	6.3	-	1.4	-	-	1.65	-	-
	1	(1)	0.27	1.4	0.5	5	0.15	1.3	-	-	1.3	5.8	42 HRc
	2	(1)	0.27	1.4	0.55	5.7	0.15	1.35	-	-	1.55	5.5	44 HRc*

* 50 HRC after post weld heat treatment of 525°C during 6 hours.

PACKING

25 kg (pail) : SAP Stock number : 25206. (standard)
25 kg (bag) : SAP Stock number : 29100. (on request)