

## DESCRIPTION

- Highly basic agglomerated flux for Electroslag strip hardfacing of cobalt based alloys.
- Its special formulation allows to reach the required full chemistry in 2 layers.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 4 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 - 1.0 mm ( 18 x 60 Mesh ASTM )
- Apparent density 0.9
- Consumption 0.7 ( 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)	7	15

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

- Base metal 0.2 % C - steel.
- Strip dimensions 30 X 0.5 mm
- Cladding parameters 500 A - 26 V -10 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	W	Fe	Co	Thickn. (mm)	Hardness
Stellite 6	-	S CoCr6	1.10	0.60	0.05	29.5	-	-	5.2	2	Bal.	-	-
	1	S CoCr 6	0.95	0.35	0.25	28	0.1	-	4.8	6	Bal.	5	40 HRc
	2	S CoCr6	1.05	0.45	0.30	29	0.1	-	5.0	3	Bal.	4.5	44 HRc
Stellite 21	-	S CoCr21	0.3	0.5	0.5	27.5	3	5.4	-	2.5	Bal.	-	-
	1	S CoCr21	0.3	0.2	0.4	24.5	1.5	5.3	-	10	Bal.	5	30HRc
	2	S CoCr21	0.25	0.35	0.45	25.7	3	5.3	-	3	Bal.	4.5	32 HRc

## PACKING

- 25 kg (pail) : SAP Stock number : 29195. (on request)  
 25 kg (bag) : SAP Stock number : 29196. (on request)