

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding at high speeds (up to 30 cm/min).
- This flux is exceptionally suitable for single layer deposit of alloy 347.
- The operational characteristics are excellent.
- If high speed conditions are not possible, this flux is perfectly suitable for the standard electroslag cladding conditions.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 6 (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
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates (kg/h)	13	24	35

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) 1350 A - 24 V - 30 cm/min.
(2) 1350 A - 24 V - 22 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Nb	N	Thickn. (mm)	Ferrite FN
347	-	24.12LNb	0.015	1.8	0.2	24.	13.	0.6	0.04	-	-
	1	(1)	0.040	1.3	0.3	18.	10.	0.4	0.04	3.5	4
	-	21.11LNb	0.015	1.8	0.1	21.	11.	0.6	0.03	-	-
	1	(2)	0.035	1.3	0.3	18.	9.5	0.4	0.03	4.2	4

PACKING

25 kg (pail) : SAP Stock number : 29104.