

DESCRIPTION

- Highly basic agglomerated flux especially designed for electroslag strip cladding of alloy 318.
- Designed to obtain a Niobium stabilised 347 alloy in one layer using SOUDOTAPE 21 11 LNb and 318 using SOUDOTAPE 21 13 3 L as well as in two layers using SOUDOTAPE 316L.
- Excellent slag removal and good wettability with the base metal.
- Low flux consumption rate.

GENERAL CHARACTERISTICS

- Current DC +
- Basicity index 3.7 (according to Bonizewski; calculated in mole %).
- Grain size 0.25 - 1 mm (18 x 60 N° 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)	10	21	33

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) 1250 A – 24 V – 17 cm/min
(2) 1250 A – 24 V – 16 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	N	Thick. (mm)	Hardness or FN
347	-	21.11LNb	0.015	1.8	0.18	21.5	11.2		0.65		5	
	1	(1)	0.03	1.24	0.4	19	10.3		0.5			
318	-	21.13.3L	0.01	1.71	0.2	20.4	14.2	2.86		0.032	4.7	5.8 FN
	1	(1)	0.03	1.32	0.31	18	12.2	2.56	0.34	0.03		
318	-	316L	0.015	1.7	0.3	18.5	12.5	2.9			4.5	
	2	(2)	0.02	1.2	0.55	18.5	12.2	2.4	0.34			

PACKING

25 kg (pail) : SAP stock number : 42024