

EN 760 : (E) SA FB 2
DIN 32522 : BFB6 6315 5DC40B-2-1

DESCRIPTION

- Highly basic agglomerated flux especially designed for high speed electroslag strip cladding with stainless steel welding strip.
- With pure austenitic or austenitic/ferritic strip, this flux is also suitable with normal welding conditions.
- Excellent slag removal and good wettability with the base metal. Lower flux consumption.
- If high speed conditions are not possible, this flux is perfectly suitable for the standard cladding conditions.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 7.8 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 Mesh ASTM)
- Apparent density 0.85
- Consumption 0.55 (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)	14	26	41

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) 1450 A - 24 V - 35 cm/min.
(2) 1450 A - 24 V - 25 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	N	Thickn (mm)	FN
308L	-	309L	0.015	1.80	0.35	23.4	12.8	-	-	0.040	-	-
	1	(1)	0.050	1.5	0.50	18.4	10.2	-	-	0.035	3.1	2
	-	308L	0.015	1.70	0.30	19.8	10.1	-	-	0.040	-	-
	2	(2)	0.025	1.30	0.40	19.2	10.1	-	-	0.035	3.0	6
316L	-	309L	0.015	1.80	0.35	23.4	12.8	-	-	0.040	-	-
	1	(1)	0.050	1.5	0.50	18.4	10.2	-	-	0.035	3.1	2
	-	316L	0.015	1.70	0.25	18.5	12.6	2.85	-	0.045	-	-
	2	(1)	0.025	1.40	0.40	18.2	12	2.30	-	0.040	3.0	5
	-	21.13.3L	0.010	1.80	0.20	20.2	14.0	2.9	-	0.035	-	-
1	(2)	0.028	1.35	0.35	17.1	12.0	2.4	-	0.030	4.2	4	
347	-	24.12LNb	0.015	1.80	0.20	24.0	13.0	-	0.65	0.045	-	-
	1	(1)	0.045	1.40	0.40	19.3	10.5	-	0.45	0.040	3.1	5
	-	21.11LNb	0.015	1.80	0.18	21.5	11.2	-	0.65	0.030	-	-
	1	(2)	0.035	1.25	0.30	18.8	9.7	-	0.45	0.025	4.2	4
	-	309L	0.015	1.80	0.35	23.4	12.8	-	-	0.040	-	-
	1	(1)	0.05	1.5	0.50	18.4	10.2	-	-	0.035	3.1	2
-	347	0.015	1.70	0.30	20.0	10.2	-	0.55	0.040	-	-	
2	(1)	0.025	1.2	0.35	19.1	10.2	-	0.35	0.03	3	6	

PACKING

25 kg (pail) :SAP Stock number : 29105.