

## DESCRIPTION

- Highly basic alloyed agglomerated flux for electroslag strip cladding of alloy 825 in one layer with Soudotape 825C.
- Excellent weldability and good wetting properties.
- Easy slag release.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 4.8 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 – 1 mm (16 x 60 N° 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	90
Typical deposition rates (kg/h)	10	20	30

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

- Base metal 0.2% C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1000 A – 24 V – 16 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Fe	Cu	Thickn. (mm)
825	-	825C	0.008	0.78	0.31	22.77	Bal.	3.09	29.97	2.36	-
	1	825C	0.030	0.69	0.59	22.7	Bal.	2.87	33.4	1.84	4.8

## CORROSION TEST

- Soudotape 825 (30 x 0.5 mm) + Record EST 138 (1 layer)
- 580 A - 25 V - 16 cm/min
- Heat treatment : 150 min at 610 – 630 °C
- ASTM A 262 – C
- Penetration in millimetres per year : 0.514 mm/year

## PACKING

25 kg (pail) : SAP Stock number :38235.