

EN 760 : (E) SA FB 2
DIN 32522 : BFB 7 6314 DC+ 40B-2-8

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of nickel base alloys.
- The low Si-content in the weld metal assures a very low hot cracking sensitivity.
- Excellent weldability and wetting action, easy slag release.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 Mesh ASTM)
- Apparent density 1
- Consumption 0.5 (kg fused flux / kg strip)
- Redrying 1 to 2 hours at 350 +/- 50°C
- Approvals TUV (with Soudotape NiCr3)
- Applicable strip dimensions :

Strip widths (mm)	30	60	90	120
Typical deposition rates(kg/h)	10	20	30	40

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) : 1100 A – 24 V – 16 cm/min.
(2) : 1100 A – 24 V – 12 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Ti	Fe	Thickn. (mm)
600	-	NiCr3	0.015	3.2	0.2	20.1	bal	-	2.6	0.3	1	-
	1	(1)	0.03	2.7	0.25	18.5	bal	-	2.2	0.03	10	4.2
	2	(1)	0.02	2.85	0.2	19.5	bal	-	2.3	0.04	4	3.6
625	-	625	0.02	0.1	0.15	22.0	bal	9.0	3.6	0.2	0.25	-
	1	(1)	0.03	0.3	0.35	19.5	bal	8.0	3.1	0.01	10	4.2
	2	(2)	0.02	0.1	0.25	21.5	bal	8.8	3.2	0.01	2.5	5.0

PACKING

25 kg (pail) : SAP Stock number : 29107.