

EN 760 : (E) SA FB 2  
DIN 32522 : BFB 7 6455DC+40B-2-8

## DESCRIPTION

- Highly basic agglomerated flux especially designed for high speed electroslag strip cladding with Soudotape NiCr3 and Soudotape 625.
- The special formulation of the flux assures good wettability and excellent slag removal.
- 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 5.2 ( 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 2hours at 350 +/- 50°C
- Approval TUV with Soudotape 625
- Applicable strip dimensions :

Strip widths (mm)	30	60	90
Typical deposition rates(kg/h)	14	29	44

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

- Base metal 0.2% C - steel.
- Strip dimensions 60X0.5 mm
- Cladding parameters 1450 A - 24 V - 35 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Thickn. (mm)
600	-	NiCr3	0.015	3.1	0.15	20.7	bal.	-	2.6	0.5	-
	1	NiCr3	0.035	2.5	0.40	17.0	bal.	-	2.1	16	3.1
	2	NiCr3	0.025	2.8	0.35	19.8	bal.	-	2.5	5	3.0
625	-	625	0.020	0.10	0.10	22.0	bal.	9.0	3.6	0.30	-
	1	625	0.035	0.25	0.30	17.0	bal.	7.8	2.7	16.0	3.1
	2	625	0.025	0.10	0.30	21.0	bal.	8.7	3.2	5.0	3.0

## PACKING

25 kg (pail) :SAP Stock number : 29110.