

## DESCRIPTION

- Highly basic alloyed agglomerated flux especially designed for high speed electroslag strip cladding with Soudotape 625 in one layer.
- The special formulation of the flux assures a level of Chromium content higher than 21% in the welding deposit.
- Excellent weldability and good wetting behaviour.
- Easy slag release.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.9 (according to Bonizewski; calculated in mole % )
- Grain size 0.25 - 1 mm (18 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)	14	28	42

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

- Base metal 0.2 % C - steel
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1450 A – 24 V – 26 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Thickn. (mm)
625	-	625	0.02	0.10	0.21	22.0	bal	9.0	3.60	0.30	-
	1	625	0.03	0.11	0.21	21.30	bal	8.20	2.80	9.40	4.3

## PACKING

25 kg (pail) : SAP Stock number :42038.