

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of Super Duplex alloy in 2 Layers with Soudotape 22.6.3L.
- Excellent weldability and good wetting.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 7.1 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 N° ASTM)
- Apparent density 1.0
- 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)	11	23	34

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

- Base metal 0.2 % C - steel.
- Strip dimensions 60 x 0.5 mm.
- Cladding parameters 1250 A – 24 V – 18 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn (mm)	FN
25.10.4 L	-	22.6.3L	0.018	1.40	0.40	22.10	6.0	3.0	0.15	-	-
	1	22.6.3L	0.029	0.80	0.34	24.90	8.90	3.90	0.10	5	54
	2	22.6.3L	0.020	0.80	0.31	26.70	9.80	4.20	0.10	5	57

PACKING

25 kg (pail) :SAP Stock number : 46226.