

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of alloy 18Cr8NiMn in 2 Layers with Soudotape 308L.
- Allowing to reach in combination with the Soudotape 309L requested CrNiMn cold workable alloy for top rail wear resistant overlaying in one single layer at working deposition rate exceeding 11 kg/h with very extra low fumes.
- Top rail overlaying width of 33-35 mm per welding run.
- Excellent weldability and good wetting properties.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 3.9 (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	22	33

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

- Base metal 0.2 % C - steel
- Strip dimensions 60 x 0.5 mm(1), 30 x 0.5 mm(2)
- Cladding parameters 1250 A – 24 V – 17 cm/min(1), 600 A – 25 V – 16 cm/min(2) .

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Thickn. (mm)
18Cr 8Ni 6Mn ⁽¹⁾	-	308L	0.015	1.70	0.30	19.80	10.10	-
	1	308L	0.079	4.24	0.48	17.0	8.70	0.7
	2	308L	0.071	5.30	0.55	18.60	9.20	4.5
18 Cr 10 Ni 4.5 Mn ⁽²⁾	-	309L	0.012	1.8	0.4	23.7	13.3	-
	1	309L	0.088	4.33	0.43	19.3	10.7	1

PACKING

25 kg (pail) :SAP Stock number : 46131.