

DESCRIPTION

- Highly basic alloyed agglomerated flux for electroslag strip cladding of alloy 308L in one layer.
- Excellent weldability and good wetting.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.3 (according to Bonizewski; calculated in mole %).
- Grain size 0.25 – 1 mm (18 x 60 N° ASTM)
- Apparent density 0.9
- Consumption 0.75 (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.
- Cladding parameters 1250 A - 24 V - 18 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	N	Thickn. (mm)	FN
308L	-	308L	0.015	1.70	0.30	19.80	10.10	0.030	-	-
	1	308L	0.024	1.28	0.42	19.80	10.0	0.029	4	7

PACKING

25 kg (pail) : SAP Stock number : 42030.