

DESCRIPTION

- Highly basic agglomerated flux designed for Electroslag strip cladding.
- This flux is especially developed to reach the chemical analysis of a 28Cr-23Ni-3Mo LN alloy-type in 2 layers with SOUDOTAPE 309L and SOUDOTAPE 310MM.
- This flux allows also to deposit in two layers a 25Cr-22Ni-2Mo LN alloy-type in 2 layers. The first layer has to be cladded with SOUDOTAPE 309L and RECORD EST 122 and the second layer with SOUDOTAPE 310MM and RECORD EST 310MM
- Excellent slag removal and good wetability with the base metal.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 3.4 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 N° ASTM)
- Apparent density 0.95
- Consumption 0.55 (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 (1) 1000A / 24V / 16cm/min.
(2) 1250A / 24V / 18cm/min

Alloy	Layer	Flux Record	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)
28.23.3	-		309L	0.01 2	1.75	0.45	23.7	13.5	0.03	0.05 5	-
	1 (1)	EST 310MM	-	0.03 4	1.01	0.35	24.4	14.8	1.1	0.05 3	4
	-		310MM	0.01 5	4.61	0.24	25.2	22.7	2.3	0.13 1	-
	2 (1)	EST 310MM	-	0.01 7	2.96	0.32	28.1	23.4	2.9	0.09 6	4
310	-		309L	0.01 2	1.75	0.45	23.7	13.5	0.03	0.05 5	-
	1 (2)	EST 122	-	0.03 9	1.31	0.48	18.9	10.7	0.02	0.05 3	-
	-		310MM	0.01 5	4.61	0.24	25.2	22.7	2.3	0.13 1	-
	2 (1)	EST 310MM	-	0.01 4	2.75	0.31	27.4	22.7	2.7	0.13 1	-

PACKING

25 kg (pail) : 68231