

DESCRIPTION

- Highly basic alloyed agglomerated flux for electroslag strip cladding of alloy 316L in one layer.
- Excellent weldability and good wetting characteristics.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.6 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 – 1 mm (18 x 60 Mesh ASTM)
- Apparent density 1.0
- 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	23	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 - 16 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
316L	-	316L	0.012	1.70	0.26	18.60	12.70	2.69	0.055	-	-
	1	316L	0.02	1.20	0.29	19.40	12.80	2.60	0.058	4.8	6.5

PACKING

25 kg (pail) : SAP Stock number : 42031.