

DESCRIPTION

- Highly basic agglomerated flux for Electroslag strip cladding of alloy 317L in one layer with Soudotape 21.13.3L
- Excellent weldability and good wetting
- Easy slag removal even at high temperatures

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.5 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1 mm (18 x 60 N° 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)	12	24	36

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

- Base metal 2 ¼Cr 1Mo
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1350 A - 24 V - 25 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
317L	-	21.13.3L	0.010	1.60	0.23	21.2	14.8	2.80	0.020	-	-
317L	1	21.13.3L	0.015	1.20	0.30	18.5	13.8	3.20	0.030	4	7

PACKING

25 kg (pail): SAP Stock number: 46082