

DESCRIPTION

- Highly basic alloyed agglomerated flux for Electroslag strip cladding of alloy 347 in one layer.
- Excellent weldability and good wetting.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.4 (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	Nb	Thickn. (mm)	FN
347	-	347	0.015	1.70	0.30	20.0	10.20	0.55	-	-
	1	347	0.025	1.20	0.39	18.40	9.70	0.32	4	6

PACKING

25 kg (pail) : SAP Stock number : 46367.