

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of Alloy 400 (Monel) in 2 Layers with Soudotape NiCu7.
- Excellent weldability and good wetting.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 6.2 (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)	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 1100 A – 26 V – 16 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Ni	Cu	Ti	Fe	Thickn. (mm)
400	-	NiCu7	0.02	3.40	0.29	bal.	30.40	2.0	0.30	-
	1	NiCu7	0.038	2.95	0.56	bal.	26.30	0.53	10.90	5
	2	NiCu7	0.016	3.27	0.53	bal.	28.20	0.69	2.30	5

PACKING

25 kg (pail) : SAP Stock number : 29106.