

## DESCRIPTION

- Highly basic agglomerated flux for Electroslag strip cladding hardfacing with Soudotape 420.
- Record EST 423 flux has especially been developed to reach the hardness level of 52 HRc in the deposit in 3 Layers.
- The presence of Molybdenum improves properties at high temperature.
- Easy slag release.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.0 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 - 1 mm (18 x 60 N° ASTM )
- Apparent density 0.9
- Consumption 0.7 ( 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 0.2 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1250 A - 24 V - 17 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Mo	Thickn. (mm)	Hardness (HRc)
420	-	420	0.33	0.32	0.25	13.20	-	-	-
	1	420	0.27	0.36	0.15	10.50	1.38	4.3	52
	2	420	0.28	0.24	0.14	12.80	1.80	4.2	52
	3	420	0.29	0.25	0.12	12.90	1.84	4.2	52

## PACKING

25 kg (pail): SAP Stock number: 43465.