

EN 760 : (E) SA FB 3  
DIN 32522 : BFB 4 553 DC+40B-2-12

## DESCRIPTION

- Highly basic agglomerated flux designed for high speed Electroslag strip cladding with Soudotape 420.
- Its special formulation allows to reach the required properties in 2 layers.
- Very good fusion, good wet ability and automatic slag removal.
- If high speed conditions are not possible, this flux is perfectly suitable for the standard Electroslag cladding conditions.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 8 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 - 1 mm (18 x 60 Mesh ASTM )
- Apparent density 0.85
- Consumption 0.55 ( 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)	13	26	40

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

- Base metal 0.2 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 1400 A - 24 V - 24 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Thickness (mm)	Hardness or FN
420	-	420	0.3	0.3	0.2	13.6	-	-
	1	420	2	0	5	10.6	4.4	50 HRc
			9	0	5			
	2	420	0.3	0.3	0.2	12.6	4.2	50 HRc
			1	0	8			

## PACKING

25 kg (pail) : SAP Stock number :29200.  
25 kg (bag): SAP Stock number : 29201.