

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding of Duplex alloy in one layer with Soudotape 22.6.3L.
- Excellent weldability and good wetting.
- Easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 4.7 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 - 1mm (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	23	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 – 18 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
Duplex	-	22.6.3L	0.025	1.64	0.39	22.5	5.6	3.14	0.17	-	-
	1	22.6.3L	0.034	1.04	0.29	22.0	6.4	3.05	0.12	5	49

PACKING

25 kg (pail) : SAP Stock number : 42029.