

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding.
- In combination with Soudotape 430, Record EST 452 deposits a 13Cr-4Ni-1Mo in 3 layers.
- Excellent technology and easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 4.5 (according to Bonizewski; calculated in mole %)
- Grain size 0.25 – 1 mm (18 x 60 Mesh 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 1100 A - 24 V -16 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickn (mm)	Hardness
13 Cr 4 Ni 1 Mo	-	430	0.045	0.42	0.26	16.30	0.14	0.02	-	-
	1	430	0.062	0.46	0.36	11.70	3.03	0.36	4	38 HRc
	2	430	0.052	0.34	0.39	14.10	3.30	0.39	3.5	38 HRc
	3	430	0.045	0.32	0.37	14.80	3.60	0.45	3.5	38 HRc

PACKING

25 kg (pail) :SAP Stock number : 42033.