

DESCRIPTION

- Highly basic agglomerated flux for electroslag strip cladding on rolls.
- In combination with Soudotape 430, Record EST 453 deposits a 13Cr-4Ni-1Mo in 3 layers.
- Excellent technology and easy slag removal even at high temperatures.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 3.4 (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 900A – 24V – 16cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickn. (mm)	Hardness
13 Cr 4 Ni 1 Mo	-	430	0.06	0.34	0.36	16.2	-	-	-	-
	2		0.04	0.22	0.45	14.8	3.95	0.91	4	41.5HRc
	3	430	0.04	0.22	0.45	14.8	3.95	0.91	4	

PACKING

25 kg (pail) : SAP Stock number : 61672