

## DESCRIPTION

- Highly basic alloyed agglomerated flux for electroslag strip cladding of alloy 625 in one layer with a standard strip SOUDOTAPE 625.
- Very good weld properties, very easy slag release and as nice bead profile.
- Allow very high deposition rates and represents one of the most economical way of cladding alloy 625 on mild steel and medium alloyed steel grades heavy components regarding to conventional welding processes.
- The low Si-content in the weld metal ensures a very low hot cracking sensitivity.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 5.1 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 - 1 mm (18 x 60 Mesh ASTM )
- Apparent density 1,0 kg/dm<sup>3</sup>
- 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)	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 1250 A – 24 V – 17 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Thickness (mm)
625	-	625	0.013	0.10	0.10	22.1	bal.	8.5	3.65	0.22	5.5
	1	625	0.022	0.15	0.32	22.6	bal.	8.4	3.40	6.8*	

\* : Value that can be only guaranteed with an extended stick-out of 45 mm.

## PACKING

25 kg (pail) : SAP Stock number : 51447.