

## DESCRIPTION

- Highly basic agglomerated flux especially designed for the electroslag strip cladding with Soudotape 690.
- The special formulation assures maximum hot cracking resistance.
- Very easy slag removal and good wetting.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 4.7 ( according to Bonizewski; calculated in mole % )
- Grain size 0.25 – 1 mm (18 x 60 Mesh ASTM )
- Apparent density 0.85
- Consumption 0.8 ( kg fused flux / kg strip )
- Redrying 1 to 2 hours at 350 +/- 50°C
- Applicable strip dimensions :

|                                |     |    |
|--------------------------------|-----|----|
| Strip widths (mm)              | 30  | 60 |
| Typical deposition rates(kg/h) | 7.5 | 15 |

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

- Base metal 0.2 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters 900 A - 24 V - 17 cm/min.

| Alloy | Layer | Strip Soudotape | C     | Mn  | Si   | Cr   | Ni   | Fe   | Nb  | Thickn. (mm) |
|-------|-------|-----------------|-------|-----|------|------|------|------|-----|--------------|
| 690   | -     | 690             | 0.019 | 2.7 | 0.20 | 30.6 | Bal. | 8.8  | 1.8 | -            |
|       | 1     | 690             | 0.040 | 2.3 | 0.34 | 25.7 | Bal. | 20.7 | 1.6 |              |
|       | 2     | 690             | 0.025 | 2.4 | 0.26 | 28.8 | Bal. | 12.0 | 1.8 |              |
|       | 6     | 690             | 0.020 | 2.5 | 0.26 | 29.7 | Bal. | 9.5  | 1.8 |              |

## PACKING

25 kg (pail) SAP Stock number : 29111.