

DESCRIPTION

- Agglomerated flux for submerged arc strip cladding especially developed to reach the chemical analysis of alloy 317L in 2 Layers.
- First Layer with Soudotape 21.13.3 L and Second Layer with Soudotape 316L.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.86 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 1.0
- Consumption 0.6(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	13

For widths over 60 mm, the electroslag strip cladding process is recommended.

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

- Base metal 0.2% C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters (1) 750 A - 26 V - 11 cm/min
(2) 750 A - 26 V - 12 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
317L	-	21.13.3L	0.01	1.80	0.20	20.20	14.0	2.90	-	-	-
	1	(1)	0.041	1.43	0.68	17.90	11.50	2.81	0.042	4.7	7.3
	-	316L	0.012	1.70	0.26	18.60	12.70	2.69	0.055	-	-
	2	(2)	0.025	1.37	0.71	18.60	12.60	3.12	0.047	4.2	7.1

PACKING

25 kg (pail) : SAP Stock number : 47191.