

EN ISO 14174 : SA AB 2
DIN 32522 : BAB5 7455DC+15B-3-16

DESCRIPTION

- Agglomerated flux for submerged arc strip cladding with CrNi stainless steel strips.
- Recommended for cladding with non-stabilised Cr-Ni stainless steel strips.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.89 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 0.9
- 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)	10	14

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 - 27 V - 12 cm/min.
(2) 750 A - 26 V - 14 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Mo	Thickness (mm)	FN
308L	-	309L	0.015	1.65	0.35	23.6	13.1	-	-	-
	1	(1)	0.040	1.30	0.75	19.5	11.2	-	4.3	7
	-	308L	0.015	1.80	0.30	19.8	10.5	-	-	-
	2	(1)	0.025	1.70	0.50	19.4	10.2	-	4.1	7
316L	-	309L	0.015	1.65	0.35	23.6	13.1	-	-	-
	1	(2)	0.040	1.30	0.75	19.5	11.2	-	4.0	7
	-	316L	0.015	1.70	0.30	18.5	12.5	2.9	-	-
	2	(2)	0.025	1.50	0.50	18.2	11.4	2.4	3.7	9

PACKING

25 kg (pail) : SAP Stock number : 29080.
25 kg (bag): SAP Stock number : 2908.