

DESCRIPTION

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

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 0.92 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 0.7
- 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 | 90 |
| Typical deposition rates (kg/h) | 10 | 20 | 30 |

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 750 A – 27 V -12 cm/min.

| Alloy | Layer | Strip Soudotape | C | Mn | Si | Cr | Ni | Nb | Thickn. (mm) | FN |
|-------|-------|-----------------|-------|-----|------|------|------|------|--------------|----|
| 347 | - | 24.12LNb | 0.015 | 2.0 | 0.25 | 23.8 | 12.6 | 0.80 | - | - |
| | 1 | 24.12LNb | 0.055 | 1.1 | 0.75 | 18.5 | 10.5 | 0.60 | 4.5 | 5 |
| | - | 347 | 0.015 | 1.7 | 0.30 | 20.3 | 10.2 | 0.55 | - | - |
| | 2 | 347 | 0.035 | 1.1 | 0.85 | 19.2 | 10.3 | 0.55 | 4.0 | 9 |

PACKING

25 kg (pail) : SAP Stock number :29082.
25 kg (bag): SAP Stock number :29083.