

EN 760 : SA CS 2 Cr
DIN 32522 : BCS5 81549DC+15B-3-16

DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding with Cr – Ni stainless steel strips.
- Suitable for non-stabilised and stabilised grades.
- Outstanding arc stability over a wide range of welding parameters.
- Excellent slag removal and good overlapping between adjacent beads.

GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.2 (according to Bonizewski; calculated in mole %)
- Grain size 0.6 – 2.0 mm (10 x 30 Mesh ASTM)
- Apparent density 1.1
- 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	14

For widths over 60mm, 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) 900 A -28 V - 12 cm/min.
(2) 750 A -28 V – 15 cm/min

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cr	Ni	Nb	Thickn. (mm)	FN
347	-	24.12LNb	0.015	2.00	0.25	23.8	12.6	0.80	-	-
	1	(1)	0.050	1.00	0.75	20	10.0	0.50	5.0	5
	-	309L	0.012	1.80	0.40	23.7	13.3	-	-	-
	1	(2)	0.045	0.90	0.80	18.2	9.7	-	3.5	2
	-	347	0.016	1.70	0.40	19.7	10.5	0.50	-	-
308L	2	(2)	0.035	0.80	0.90	19.3	10.0	0.40	3.1	6
	-	309L	0.012	1.80	0.40	23.7	13.3	-	-	-
	1	(1)	0.045	0.90	0.80	19.3	10.6	-	4.5	4
	-	308L	0.013	1.70	0.40	20.3	10.4	-	-	-
	2	(1)	0.030	1.00	0.80	19.5	10.2	-	4.2	6

PACKING

25 kg (pail) : SAP Stock number : 29086.
25 kg (bag): SAP Stock number : 29087.