

## DESCRIPTION

- Agglomerated basic flux for submerged arc strip cladding of the 2205 duplex alloy in two or three layers in combination with SOUDOTAPE 22.6.3 L
- Good slag removal and good overlapping behaviour between adjacent beads.

## GENERAL CHARACTERISTICS

- Current DC+
- Basicity index 1.2 ( according to Bonizewski; calculated in mole % )
- Grain size 0.4 – 1.4 mm ( 14 x 40 N° ASTM )
- Apparent density 1.1
- Consumption 0.6 ( kg fused flux / kg strip )
- Redrying 1 to 2 hours at 350 +/- 50°C

## 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 -26 V - 17 cm/min.

Alloy	Layer	Strip SOUDOTAPE	C	Mn	Si	Cr	Ni	Mo	N	Thickn. (mm)	FN
22.6.3L	-	22.6.3L	0.014	1.5 5	0.3 3	21. 6	5.5	2.98	0.149	-	-
	2	22.6.3L	0.028	0.8 8	0.9 1	20. 9	5.92	2.78	0.147	3.5	63
	3	22.6.3L	0.027	0.8 7	0.9 7	21. 7	6.6	2.95	0.152	4.4	72

## PACKING

25 kg (pail) : SAP Stock number : 56632